

Historic, archived document

Do not assume content reflects current scientific knowledge, policies, or practices.





USDA, National Agricultural Library
NAL Bldg
10301 Baltimore Blvd
Beltsville, MD 20705-2351

N 5211a
1964

Manual of MEAT INSPECTION PROCEDURES of the United States Department of Agriculture

U. S. DEPT. OF AGRICULTURE
NATIONAL AGRICULTURAL LIBRARY

SEP 3 1968

CURRENT SERIAL RECORDS



UNITED STATES DEPARTMENT OF AGRICULTURE
CONSUMER AND MARKETING SERVICE
MEAT INSPECTION

234452

This manual contains instructions on procedures to be used in carrying out the laws and regulations relating to Federal meat inspection. This material shall be regarded therefore as implementing the regulations contained in Subchapters A and D, Chapter III, Title 9 of the Code of Federal Regulations.

Any revisions to this manual will be issued as revised pages. The following pages should be used as a control to assure receipt of all changes. Changes will be issued as Change 1, Change 2, etc. In the event a particular change is not received, meat inspection employees, plant managements, and State officials may obtain copies from the appropriate District Office; subscribers may obtain copies from the Government Printing Office; and Foreign countries may obtain copies by requesting them from the U. S. Department of Agriculture, C&MS, Meat Inspection Administrative Staff, Washington, D. C. 20250.

Revised July 1968

RECORD OF CHANGES

[illegible]

INDEX

Section

Abscesses:	
cervical-----	310.10(B)(7)
hog heads-----	311.4
pork tongues-----	310.10(F)(2)
Accidents, control and prevention-----	307.2
Acidification, casings-----	318.65
Actinomycosis, lesions of, cattle-----	310.10(A)(11)
Added Substance, cured product and smoked pork product-----	318.74
Address:	
of firm, labeling-----	317.24
Microbiology Laboratory-----	318.70(K)(3)(f)
Advertising:	
containers bearing marks of inspection, used for-----	317.6
use of marks of inspection-----	316.1
Albumin from inedible material, not approved-----	318.18
Algeria, special export requirements-----	324.20
Allspice (pimento)-----	317.19
Aluminum:	
foil in contact with product-----	317.11
staining of product-----	308.12(G)
Anaplasmosis, recovered cases-----	311.21
Animal Health Division:	
blood samples collected for-----	322.10
brucellosis reactors, report of findings-----	309.5(D)(5), 311.8
charges for inedible export certification-----	340.5
cleaning and disinfection of vehicles-----	322.9
market cattle testing program-----	322.10
reports of diseased animals-----	322.1-322.6
specimens of lesions suspected of being tuberculous-----	311.6(D)(E)
tuberculin reactors, report of findings-----	309.5(D)(4)
Animal Foods:	
carcasses of animals affected with certain conditions-----	311.23
interstate transportation-----	325.16
Animals:	
ante-mortem inspection-----	309.1-309.5
carelessness in handling-----	309.5(D)(7)
cruelty to-----	309.5(D)(7)
dead, permission to enter official establishment-----	313.2
emergency slaughter-----	309.5(D)(1)
escaped animals-----	309.5(D)(9)
humane slaughter-----	380, 381
only those eligible for human food purposes	
to be presented for inspection-----	309.1

Ante-Mortem Inspection:

animals still and in motion-----	309.3
calves, lacking in vigor-----	309.5(C)
cattle, injection of proteolytic enzymes-----	309.4
facilities for-----	309.1
horses-----	309.2(G)
in veterinary biological establishments-----	309.5(D)(6)
pens, equipment, and help furnished by establishment-----	309.2
pesticides, exposure to-----	309.15
requirements for-----	309.1-309.5
tuberculin reactors, identification-----	309.5(D)(4)
vesicular conditions in hogs-----	309.5(D)(2)
Anthrax, in swine on slaughtering floor-----	310.16
Antibiotic injections, cattle-----	311.22

Anticaking agents:

salt, seasoning or curing mixtures containing-----	318.20
substances acceptable-----	318.82
Appeals from inspector's decision, report-----	321.1

Applications:

Certification, Food Inspection, Identification and Specification Examination Service-----	340.4
inspection-----	304.1
Approved public refrigerated warehouses-----	318.9, 340.1

Argentina:

certificate, horse meat from-----	329.17
special export requirements-----	324.23

Armed Forces, smoked hams for-----	318.35
------------------------------------	--------

Army, grading of meats for-----	316.12
---------------------------------	--------

Arsenic-----	311.25(D)
--------------	-----------

Arthritis, disposition of hog carcasses

affected with-----	311.1
--------------------	-------

Atrophic rhinitis, hogs affected with-----	311.10
--	--------

Australia, special export requirements-----	324.25
---	--------

Austria, special export requirements-----	324.27
---	--------

Bacon, qualification of term-----	317.41
-----------------------------------	--------

Badges:

wearing of-----	306.2
loss of-----	306.2

Bait:

malathion and sugar-----	308.4(B)(4)(5)
rodent-----	308.4(D)

Beans, acceptability of-----	318.25
------------------------------	--------

Beef:

kidneys, inspection procedures-----	310.17
reinspection procedures-----	318.8
tenderloins, application of inspection legend-----	316.18
viscera separation-----	310.10(F)

Belgium, special export requirements-----	324.31
Bile Duct:	
opening of, cattle-----	310.10(A)(9)
opening of, sheep-----	310.10(D)(2)
Biological Residues:	
in meat-----	311.25
chlorinated hydrocarbon pesticide compounds-----	311.25(A)
disposition of carcasses and parts-----	311.25(G)
fungicides-----	311.25(C)
inorganic lead, arsenic, mercury, and selenium-----	311.25(D)
organo-phosphorus pesticide compounds-----	311.25(B)
samples of import meat products for residue determinations-----	311.25(H)
submission of tissue samples for biological residue analysis-----	311.25(F)
veterinary drugs, used for the treatment and prevention	
of diseases-----	311.25(E)
in slaughtered animals-----	309.1, 309.5(B), 309.5(D)(8)
instructions on sampling-----	311.25
Blood samples, collected for ANH-----	322.10
Boned pork heads, description-----	317.20(C)
Boneless meat:	
inspection-----	318.8
stored in approved public warehouses-----	318.9, 340.1
Boneless pork loins:	
control during curing-----	318.32
treatment for destruction of trichinae-----	318.33
Bones:	
crushed or ground, not to be used as ingredient of	
meat food product-----	318.14
found in meat food products-----	318.5
Boning:	
control over operations-----	318.8
not regarded as processing-----	302.4
Bottoms, included in settlings-----	317.49(F)
Bouillon cubes, containing meat extract of animal fats-----	318.77
Brains:	
contamination with bullets-----	310.10(A)(1)(b)
sheep and lamb, labeling-----	317.43
Branding:	
beef tenderloins-----	316.18
calf carcasses-----	316.16
number of imprints-----	316.17
only legible imprints allowed-----	316.1
rabbinical-----	316.8
(Also see Marking)	
Brands:	
cast steel burning-----	316.9
control over-----	316.2, 316.4

Brands: Continued

drilling hot iron brands-----	316.9
furnished by establishment-----	316.2
grade, buyers, etc., placing of-----	316.8
hot ink type-----	316.11
Identification Service-----	340.1
import, horse meat-----	329.18
imprints to be clear and legible-----	316.8
inventory to be maintained-----	316.7
property accountability no longer maintained-----	316.5
replacement-----	316.6
uniformity in size and design-----	316.3
unservicable, disposal-----	316.5
use on different species-----	316.17(B)
"US Passed for Cooking" and "US Condemned"-----	310.5
Braunschweiger, product labeled as-----	317.54
Bribery, attempted-----	323.2
Brucellosis:	
cattle reacting to test-----	310.10(A)(13)
reactors, ante-mortem-----	309.6
reactors, improperly identified-----	311.7
reactors, reporting of-----	311.7
Brushes:	
fountain type, washing carcasses-----	310.12
marking, not permitted for applying labeling features-----	317.4
Buffalo:	
slaughter-----	302.2
use in meat food product-----	302.2
Buttermilk, dried, use not approved-----	318.17
Calcium caseinate, use not approved-----	318.17
Calves:	
adequate dressing facilities-----	310.10(C)(5)
ante-mortem inspection-----	309.13
carcasses, marking-----	316.16
carcasses, shipped with skin attached, marking-----	316.16
cuts from carcasses marked at another establishment-----	316.16
dressing procedures-----	310.10(C)
heads, washing of-----	310.10(C)(2)
post-mortem inspection requirements-----	310.10(C)
rail inspection-----	310.10(C)(4)
skinning-----	310.10(C)(4)
unborn, skinning-----	314.3
viscera inspection-----	310.10(C)(3)
viscera separation-----	310.10(F)
Canada:	
cattle from slaughtered-----	322.8
certificate, horse meat from-----	329.17
special export requirements-----	324.37
collagen, added to product during rework-----	318.62
flushed before stuffing-----	318.50

Canning:

acidity, product having minimum pH-----	318.45
cold spots, checks for-----	318.40
contamination of Pullman-type cans-----	318.48
cured hams for-----	318.30
cured product, control-----	318.74
date and identity on hermetically sealed glass containers-----	317.9
defective containers, handling-----	318.43
filling lines-----	318.39
frankfurters, added water-----	318.59
handling and shipping product-----	318.42
heat processing of product-----	318.39
hermetically sealed containers-----	318.39
incubation of test samples-----	318.46
jet vacuum equipment-----	318.48
net weight determination-----	317.32-317.35
overfilling-----	318.39
"Perishable, Keep Under Refrigeration"-----	318.38
reprocessing canned product-----	318.43
restrictions for canning refrigerated product-----	318.38
steam pressure cooking, products processed without-----	318.44
temperature of sausage prior to-----	318.41

Carcasses:

animals affected with certain conditions, used for animal foods-----	311.23
animals injected with papain-----	316.36, 317.66
calf, skin attached, marking-----	316.16
cattle, washing of-----	310.10(A)(14)
condemned, tanking and denaturing-----	314.1-318.6
conditionally passed, cysticercus bovis, marking-----	316.15
foreign origin, marking cuts from-----	316.35
icterus, animals affected with-----	311.18
location and number of brand imprints-----	316.17
marking-----	316.14
mutilation of, unnecessary-----	310.6
shrouding-----	310.11
tagging-----	310.4
tanked, identifying numbers on-----	314.1
unopened-----	311.13
washing, sheep-----	310.10(D)(1)

Carotenosis, test for-----	311.20
----------------------------	--------

Caseous lymphadenitis, disposition of sheep

carcasses and parts-----	310.10(D)(4)(5)
--------------------------	-----------------

Casings:

acidification of approved dye solutions-----	318.65
added substance-----	318.50
artificial, dye-impregnated-----	318.66

Casings: Continued

inspection-----	318.49
mineral or vegetable oil applied to outer surfaces-----	318.53
net weight statement-----	317.29
oil as mold inhibitor-----	318.53

Cattle:

carcasses, identification for Meat Grading Branch-----	322.7
dressing procedures-----	310.10(A)(7)
enzyme solutions, ante-mortem injection-----	309.4
post-mortem inspection requirements-----	310.10(A)
tuberculin test-----	311.5
washing of carcasses-----	310.10(A)(14)

Ceilings, control of condensation-----	308.12(M)
--	-----------

Center cut, loins and pork chops-----	317.21
---------------------------------------	--------

Cereal:

definition, labeling-----	317.20(D)
mettwurst, not permitted ingredient in-----	318.58
thuringer or corned beef hash, not permitted ingredient-----	318.57

Certificates. See export certificates, import

certificates, shipper's certificates

Certification of commercial curing compounds-----	318.83
---	--------

Certification Service:

application for-----	340.4
charges for-----	340.5
export product-----	340.2
purpose-----	340.2

Charges:

disinfection of vehicles-----	322.9
Meat Grading Branch, products examined by-----	322.7

Cheek trimmings-----	317.22(A)
----------------------	-----------

Cheese, in statement of ingredients-----	317.20(P)
--	-----------

Chile con carne, content of-----	317.53
----------------------------------	--------

Chilling and freezing procedures-----	318.80
---------------------------------------	--------

Chloramine T, for shipping specimens-----	311.6(C)
---	----------

Chlorinated hydrocarbon-----	311.25(A)
------------------------------	-----------

Cholera, swine, reporting-----	322.6
--------------------------------	-------

Chopped beef, definition-----	317.46
-------------------------------	--------

Chopping or grinding, regarded as processing-----	302.4
---	-------

Chutes, to be hooded and vented-----	313.1
--------------------------------------	-------

Cleaning materials:

acceptable-----	308.2(A)
not acceptable-----	308.2(A)
vehicles-----	322.9

Cloths, dressed carcasses, wetting of-----	310.11
--	--------

Coal tar dyes, certification required-----	318.66
--	--------

Codes:

laboratory-----	320.6
products-----	320.2

Cold spots, heat processing equipment-----	318.27, 318.40
--	----------------

Colombia, special export requirements-----	324.43
--	--------

Coloring artificial:	
ingredients statement-----	316.22
penetration, examination for-----	318.67
Common name-----	317.14, 317.56
Communicable disease:	
reports-----	322.1, 322.2, 322.6
transmission-----	308.13(H)
Condemned products:	
carcasses, tanking and denaturing-----	314.1-314.6
control of, removal from premises-----	314.5
reporting, on reinspection-----	318.4
tanking-----	314.1-314.6
Condensation, control of-----	308.12(M)
Condiments, added to sausage-----	318.55
Containers:	
acceptable for use-----	308.12(N)
animal casings used as-----	318.50
boneless meat-----	318.8
curing mixtures and seasonings-----	318.16
deceptive filling-----	317.31, 318.39
establishment number embossed on-----	317.8
hermetically sealed-----	317.8, 317.9
ingredients, statement of-----	317.3
jet-type equipment for cleaning-----	318.48
labeling-----	317.3-317.9
net, gross and tare weights-----	317.25-317.29
restricted products, sealing-----	325.9
secondhand, inspection and cleaning-----	308.15(I)(J)(K)
shipping-----	316.30-316.34
Contaminants, foreign material:	
brushes, steel wool-----	308.12(H)
burlap-----	308.12(O)
cloth lint-----	308.12(P)
containers-----	308.12(N)
drums, lacquer-----	308.12(W)
elevator, shafts-----	308.12(S)
enamelware-----	308.12(K)
glass, light bulbs-----	308.12(L)
lead-----	308.12(V)
lubricants-----	308.12(T)
metals-----	308.12(W)
metal truck-----	308.12(I)
metal, wire-----	308.12(F)
nails-----	308.12(D)
needle injectors-----	308.12(J)
paint, rust, condensation-----	308.12(M)
paper, staples-----	308.12(E)

Contaminants, foreign material: Continued

sawdust-----	308.12(Q)
shovels-----	308.12(A)
sprays, cookers-----	308.12(U)
staining, aluminum-----	308.12(G)
staples-----	308.12(B)
tag fasteners-----	308.12(C)
walls, posts-----	308.12(R)
wood splinters-----	308.12(D)
wrapping machines-----	308.12(X)

Contamination:

accidental, cleaning of product-----	318.1
at time of evisceration, hogs-----	310.10(B)(3)
bacterial-----	308.13
by bone-in meat products-----	318.5
canning lines-----	318.48
carcasses, horse-----	310.10(E)(1)
equipment, care of-----	308.15
labeling, improper-----	317.10, 317.11
rodents, dirt, and the like-----	318.70
sources of, and suggestions for elimination-----	308.18

Cooked ham, labeling-----	317.47
---------------------------	--------

"Cooked" or "fully cooked," use of term-----	316.24(B)
--	-----------

Cookers, Jourdan-type-----	308.12(U)
----------------------------	-----------

Cooperation:

with local authorities-----	322.13
with Public Health Service-----	322.14

Copper, not acceptable if in contact with product-----	308.12(V)
--	-----------

Corned beef, imported, inclusion of head, cheek, or heart meat-----	327.4
---	-------

Corned beef hash:

cereal not permitted-----	318.57
preparation for compliance-----	318.90

Corn syrup:

ingredient statement-----	317.20(G)
solids, limitations-----	318.26, 318.29

Country style, term used in connection with sausage-----	317.17
--	--------

Cracker meal, labeling, declared as such-----	317.20(I)
---	-----------

Cracklings, not acceptable as ingredients of meat food products-----	318.79
--	--------

Cruelty to animals, correction of practices constituting-----	309.5(D)(7)
---	-------------

Crusts or dough used in preparing pizza pies-----	318.81
---	--------

Cured meats:

boneless pork loins treated for destruction of trichinae-----	318.31, 318.32
canned-----	318.38
monosodium glutamate or hydrolyzed plant protein	
added to pickle-----	318.29
solutions injected into meat-----	318.28
use in fabricated product-----	316.28, 316.62

Curing compounds, commercial, certification required-----	318.83
---	--------

Curing mixtures:

anticaking agents, acceptable as-----	318.83
approval and labeling-----	318.16

Cutlet, veal-----	317.61
Cutting boards, cleaning-----	308.15(E)
Cysticercus bovis, carcasses conditionally passed for food on account of, marking-----	316.15
Cysticercus cellulosae, reporting-----	311.16
Czechoslovakia, special export requirements-----	324.49
Dead animals, requirements to bring on premises-----	313.2-313.3
Deceptive filling-----	317.31
Defrosting of product-----	318.3
Dehydrated:	
celery-----	317.20(F)
garlic-----	317.20(F)
onions-----	317.20(F)
potatoes-----	317.20(L)
Denaturants for inedible fats-----	325.18
Denaturing:	
agents, condemned products-----	314.2
requirements-----	314.2
uninspected product shipped interstate-----	325.16, 325.18
Deviled meat food product, water content-----	317.58
Disease, transmitted by food handler-----	308.13(H)
Diseased Animals:	
brand identification-----	322.4
carcasses and parts, disposal-----	311.1
disinfection of vehicles containing-----	322.9
Federal and State officials, reports to-----	322.1, 322.2
tuberculosis eradication-----	322.5
Disinfection and cleaning, trucks and railroad cars-----	322.9
Disinfection, for anthrax-----	310.16
Dog food, interstate transportation-----	325.16
Domestic meat labels:	
replacement of detached-----	316.33
shipping containers enclosing combination of products-----	316.30
Dominican Republic, special export requirements-----	324.53
Downers, slaughtered as suspects-----	309.5(A)
Dressing procedures, cattle-----	310.10(A)
Drums:	
acceptability for use-----	308.12(N)
coated with lacquer-----	308.12(W)
secondhand-----	308.15(J)
Dry salt cured, product designated as-----	317.42
Dye solutions:	
acidification of-----	318.65
artificial casings-----	318.66
red dye number 4-----	318.92
Dyes, stencils, used on containers-----	317.4, 317.5
Ecuador, special export requirements-----	324.55
Egg:	
products other than shell, inspection required-----	302.3(B)
use in meat food products-----	302.3(B)

Elk:	
slaughter-----	302.2
use in meat food product-----	302.2
Emergency:	
resulting in work stoppages-----	305.3
slaughter-----	309.5(D)(1)
Employees:	
head coverings-----	308.8
smoking while on duty-----	308.6
Enamelware, prohibited-----	308.12(K)
Enzymes:	
ante-mortem injection in cattle-----	309.4
injection, reaction-----	310.13
used on meat cuts and steaks-----	318.24
Equipment:	
care of to prevent trichinae contamination-----	318.27
cleaning of articles before reuse-----	308.15(B)
contamination of product, prevention-----	308.12, 308.13
enzymes, ante-mortem injection in cattle-----	309.4
expellers, cleaning of-----	308.13(G)
galvanized metal, corrosion on-----	308.15(H)
grinder plates, reversible-----	308.13(A)
jet-type, for cleaning jars and cans-----	318.48
magnetic traps-----	308.11
post-mortem inspection-----	310.1
sausage stuffing machines, cleaning-----	308.13(D)
separate for product accidentally contaminated-----	318.1
sterilization-----	310.10(B)(9)
suitability determined by Washington office-----	318.11
tanking-----	313.1
Establishment number, applied to hermetically	
sealed containers-----	317.8
Establishments:	
access to-----	306.1
eligible for inspection-----	302.1(A)
Food Inspection Service-----	340.3
not eligible for inspection-----	302.1(B)
numbers, Identification Service-----	340.1
ownership or control of-----	304.30
vermin control-----	308.3-308.5
water supply requirements-----	308.1

Expellers, cleaning of-----	308.13(G)
Experimental drugs-----	309.5(D)(3)
Export:	
Certification Service-----	340.2
charges for inedible export certification (AHD)-----	340.5
Identification Service, product packed under-----	324.5
inedible animal products-----	324.8
inspection of products-----	324.3, 324.7, 324.8
meat byproducts, certification-----	318.80
product inspected at place other than official establishment-----	324.7
special requirements for following countries:	
Algeria-----	324.20
Argentina-----	324.23
Australia-----	324.25
Austria-----	324.27
Belgium-----	324.31
Canada-----	324.37
Colombia-----	324.43
Czechoslovakia-----	324.49
Dominican Republic-----	324.53
Ecuador-----	324.55
France-----	324.61
Germany-----	324.65
Great Britain-----	324.68
Greece-----	324.69
Guatemala-----	324.71
Haiti-----	324.74
Hong Kong-----	324.76
Ireland-----	324.80
Italy-----	324.83
Jamaica-----	324.86
Japan-----	324.88
Kenya-----	324.91
Malaysia-----	324.97
Mexico-----	324.101
Netherlands-----	324.105
New Zealand-----	324.109
Norway-----	324.113
Poland-----	324.119
St. Vincent Island-----	324.125

Export: Continued

special requirements for following countries:

Salvador-----	324.127
South Africa, Union of-----	324.133
Sweden-----	324.137
Switzerland-----	324.139
Venezuela-----	324.148

stamps and certificate requirements-----	324.1-324.9
--	-------------

Export certificates:

additional copies-----	324.6(A)
control and inventory-----	324.1(A)
destination of product-----	324.4
inedible products-----	324.8
inspection of products for which requested-----	324.3
restrictive statements-----	324.6(B)
signature of inspector-----	324.4

Export stamps, control and inventory-----	324.1(A)
---	----------

Extenders, mixed amounts-----	318.95
-------------------------------	--------

Extracts, spice having distinct red color-----	316.25
--	--------

Facilities, adequate for dressing large calves-----	310.10(C)(5)
---	--------------

Farm:

identification of product shipped interstate-----	325.15
term used in connection with sausage-----	317.17

Fatbacks, declaration on labeling-----	317.20(H)
--	-----------

Fats:

animal and vegetable, separation of-----	318.93
for deep fat frying-----	318.91
inedible, denaturing, when offered for interstate movement-----	325.18
inedible, rendering, shipping containers-----	316.34
pressings-----	317.49(G)
rendered, transportation in tank cars-----	325.10

Federal Meat Inspection Act, amenability to-----	317.65
--	--------

Fish food, condemned livers used for-----	314.6
---	-------

Flavorings:

ingredients statement-----	317.16, 317.18
smoked and imitation smoke, suitability-----	318.88
spices-----	317.16

Flies, elimination:

insecticides used-----	308.4(B)(2)
sprays, knock-down-----	308.4(B)(3)
sugar baits-----	308.4(B)(4)(5)

Flour, vegetable starch, etc., in product-----	317.20(D)
Food and Drug Administration:	
cooperation with-----	326.1
notified if material rejected for use-----	318.76
oleomargarine, inspection of-----	328.1
Food, Drug and Cosmetic Act:	
certain products subject to-----	318.77
interstate shipments in violation of-----	326.1
Food Inspection Service:	
application for-----	340.4
charges for-----	340.5
description-----	340.3
general requirements-----	340.3
Foot-and-Mouth Disease, restriction on entries from	
infected countries-----	327.2
Foreign meat establishments-----	327.9
Foreign meat inspection certificates-----	327.3
Foreign officials, facsimile signatures-----	327.39
Formalin, addition to certain samples-----	318.70(K)(2)
Forms:	
MI-407-4, Rejection of Materials-----	318.76
SRS-6, Meat Inspection Label Card-----	317.60(A)(7)(8)
Formula, strict adherence to required-----	318.10
France, special export requirements-----	324.61
Franks for mailing samples-----	318.74
Freezing and chilling procedures-----	318.80
Fried pork skins-----	317.15
Frozen product:	
cleaning-----	318.3
ice glazed-----	318.9
Fruit and Vegetable Division, C&MS:	
samples, assistance in drawing-----	322.11
Frying oils-----	318.91
Fully cooked, use of term-----	316.24(B)
Fumigants, to control vermin-----	308.4(A)(1), 308.5
Fungicides-----	311.25(C)
Galvanized metal equipment, corrosion on-----	308.15(H)
Gate valves, care of-----	308.13(F)
Gelatin:	
ingredients of certain products-----	318.21
not permitted ingredient in certain products-----	317.44
Germany, special export requirements-----	324.65
Glass bottles, not permitted in processing departments-----	308.12(L)
Glass containers, labeling-----	317.9
Glycerin, not to be added to product-----	318.22
Government agencies-----	302.1(A)(B)
Grading:	
cuts to bear same designation as carcass-----	316.12
Meat Grading Branch, examination by-----	322.7
terms used only by Meat Grading Service-----	316.12

Grading Service:

grading terms used-----	316.12
markings applied by-----	316.13
Gratuities, acceptance from packers prohibited-----	323.1
Gravy mixes, and the like, containing meat extract or animal fats-----	318.77
Great Britain, special export requirements-----	324.68
Grinder plates, cleaning-----	308.13(A)(B)
Guatemala, special export requirements-----	324.71
Hair, contamination by-----	308.8
Hair roots, visible, freedom of meat byproducts from-----	318.6, 318.7
Haiti, special export requirements-----	324.74

Hams:

cooked, labeling-----	317.47
cured, intended for canning-----	318.30
cured, shipment of-----	318.30
Scotch style, treatment for trichinae not required-----	318.33
shankless, significance of term-----	317.48
sliced, cooked, labeling-----	317.12(B)
smoked, for Armed Forces, treatment for trichinae not required-----	318.35
Hardwood, acceptable for smoking-----	318.13(A)
Head covering, where exposed product handled-----	308.8

Heads:

cattle, inspection and handling-----	310.10(A)
sheep, contamination-----	310.10(D)(1)
sold intact, cleansing-----	310.15

Hearts:

calf, designation of-----	317.43
meat, beef, meaning of term-----	317.53

Hermetically sealed containers:

head space, ample-----	318.39
lard, bacon, and sliced dried beef in-----	318.36

Hogs:

atrophic rhinitis-----	311.10
carcasses affected with arthritis-----	311.1
carcasses, rail inspection-----	310.10(B)(6)
cholera, symptoms, reporting to ANH-----	322.6
cysticercus cellulosae, reporting-----	311.16
head inspection, post-mortem-----	310.10(B)(1)
lymph nodes, incising-----	310.10(B)(2)
lymph node tissues, removal-----	310.10(B)(7)
necks, washing of-----	310.10(B)(10)
post-mortem inspection-----	310.10(B)
rectum tied before evisceration-----	310.10(B)(3)
sterilization of implements after use on retained carcasses---	310.10(B)(9)
tongues, inspection for abscesses-----	310.10(F)(2)
tongues, mutilation of-----	310.10(F)(1)
vesicular condition-----	309.5(D)(2)
viscera inspection-----	310.10(B)(4)(5)
(Also see Swine)	

Hong Kong, special export requirements-----	324.76
Horse meat:	
Act, no exemption from inspection-----	325.16
atlantal and supraspinous bursa, examination-----	329.12
branding outer covering of product-----	329.13
certificates for interstate shipment-----	325.6
contagious diseases, reporting animals	
affected with-----	329.5
container, marking-----	329.16
dorsal bones, removal of-----	329.10
foreign certificates-----	329.17
identification when leaving official establishment-----	329.14
importation-----	327.1
import mark of inspection-----	329.18
ink used in branding-----	329.15
inspection and handling-----	329.1-329.18
livers condemned on post-mortem inspection-----	329.6
procedure for examining heads-----	329.10
prohibited in other official establishments-----	329.2
slaughter methods, effect on product-----	329.9
unfit, from hyperimmune carcasses-----	329.7
Horse meat establishments:	
pet food preparation-----	329.2
product derived from cattle, sheep, swine, and	
goats prohibited shipment with exceptions-----	329.2
walkway, elevated, around horse pens-----	329.3
Horses:	
animals showing symptoms of anthrax and other	
diseases-----	329.4
ante-mortem inspection-----	309.2
cervical inspection-----	310.10(E)(2)
contamination of carcasses-----	310.10(E)(1)
post-mortem inspection-----	310.10(E)
rail inspection-----	310.10(E)(4)
viscera inspection-----	310.10(E)(3)
Humane slaughter:	
changes in methods-----	381.2, 381.4
electric stunning devices-----	380.1
inspection withdrawn or suspended-----	381.4
reports-----	381.1-381.5
requirements-----	380.1
Hydrolyzed plant protein:	
added to pickle for cured meats-----	318.29
use in certain products-----	317.62-317.64, 318.60
Hyperimmune swine, ante-mortem inspection-----	309.7
Ice:	
glazing of frozen meat products-----	318.9
storage compartments-----	308.15(G)
(Also see Water)	

Icterus, animals affected with-----	311.18
Identification Service:	
application for-----	340.4
brands for marking product-----	340.1
charges for-----	340.5
establishment numbers-----	340.1
general requirements-----	340.1
marking of meat or container-----	340.1
meats prepared under-----	340.1
products amenable-----	340.1
sealing unmarked meats-----	340.1
Imitation sausage, labeling-----	317.39
Immediate or true container, marking-----	316.31
Import certificates:	
approved form or recognized signature-----	327.3
canned meat in several lots-----	327.6
facsimile signatures of foreign officials-----	327.39
facsimiles of approved foreign-----	327.38
foreign countries for which approved-----	327.37
foreign establishment numbers-----	327.9
horse meat-----	329.17
imported lamb-----	327.30
New Zealand spring lamb-----	327.29
rejected product, reporting-----	327.35
Import product:	
acceptability-----	327.10
canned hams and picnics-----	327.21
codes for product, country of origin and reason	
for rejection-----	327.36
correspondence concerning-----	327.26
customs bond, breach of-----	327.34
cuts, individually wrapped-----	327.15
facilities-----	327.11-327.13
foot and mouth infected countries-----	327.2
Form MI-410-----	327.36
grade markings-----	327.28
history-----	327.17
horse meat-----	329.17, 329.18
inspection at destination-----	327.7
labeling and marking-----	327.31
lamb-----	327.30
manufacturing meat-----	327.27
net weight determination-----	327.20
nonarrival of shipments-----	327.10
offal products-----	327.15
perishable canned product, ANH requirements-----	327.25
personal consumption entries:	
limits-----	327.32
ANH Division requirements-----	327.33
recall, after entry-----	327.23

Import product: Continued

reconditioning-----	327.22
rejected-----	327.34
reporting-----	327.34
sampling-----	327.16, 327.19
unsound cans (damaged)-----	327.24

Incubation, test samples-----318.46

Inedible product:

control of, if contain diseased organisms-----	314.5
interstate transportation-----	325.18
permits for removal-----	314.5

Ingredients:

application of list of-----	316.26
corn syrup-----	317.20(G)
cracker meal, macaroni-----	317.20(I)
crushed or ground bone not to be used-----	318.14
dehydrated celery, garlic or onions-----	317.20(F)
fixed quantities prescribed-----	317.40
gelatin-----	318.21
identity maintained-----	316.27, 318.11(A)(2)
interchanged in formula (70/30 ratio)-----	317.20(J)
labels, listing on-----	317.14, 317.20
meat loaf and the like, labeling-----	317.45
mixtures containing cereal, soya flour, nonfat	
dry milk-----	318.69
order in which shown on statement of-----	317.57
permitted and prohibited-----	318.69
preservatives-----	318.68
restricted, control of-----	318.74
sausage, certain products not acceptable-----	318.53
smoked meats, declaration-----	316.29
specific declaration-----	317.20
statement of additions-----	316.22
unacceptable for meat food product-----	318.79
unskinned pork jowls used in sausage-----	318.61
water or ice added to certain products-----	318.47
water or wine added to sausage treated for	
trichinae-----	318.64
wholesome and acceptable-----	318.11

Ink:

approved branding-----	316.10
horse meat, formula used in branding-----	329.15
preparation for use with hot iron brands-----	316.11

Insect and rodent control-----308.3-308.5

Insecticides, to control vermin-----308.4(B)(2), 308.5

Insect sprays and powders-----308.4(B)(C)

Inspection:

applications for-----	304.1
boneless meat products-----	318.8

Inspection: Continued

carcasses, unnecessary mutilation-----	310.6
establishments requiring-----	302.1
grants of-----	305.2
horse meat and product-----	329.1-329.18
nodes, organs, incision of-----	310.7
offal products-----	310.10(F)
poultry products-----	302.3(B)
procedures, in-plant-----	318.78
reinstatement-----	305.1
routine, post-mortem-----	310.10
scope-----	302
suspension-----	305.1

Inspection legend:

approval of marks of inspection-----	316.1
certification of inspection and labeling-----	317.36
number and location of imprints on carcasses-----	316.17
reference to-----	317.2

Inspectors:

areas set apart for post-mortem inspection-----	310.3
conduct of employees, discussions-----	323.1
decision questioned, report of-----	321.1
final, responsibility of-----	310.8
preparation of product-----	318.11
responsibility:	

compliance with regulations-----	318.11, 318.74
composition of product-----	317.55
in-plant procedures-----	318.78
maintaining wholesome product-----	318.81
preparation of meat products-----	318.11(D)

Ireland, special export requirements-----	324.80
Iron injections, disposition of affected parts-----	311.11
Italy, special export requirements-----	324.83
Jamaica, special export requirements-----	324.86
Japan, special export requirements-----	324.88
Jet-vacuum type equipment, for cleaning jars and cans-----	318.48
Jowls, pork slicing-----	318.6
Kenya, special export requirements-----	324.91
Keys-----	306.2
Kidney worms-----	310.10(B)(6)
Kidneys, beef, inspection procedures-----	310.17, 318.10

Labeling:

address of manufacturer or packers-----	317.24
animal food shipped interstate-----	325.16
anticaking agents-----	318.82
approval, additions to-----	317.38
boned pork heads-----	317.20(C)
canned products processed without steam pressure cooking-----	318.44
center cut-----	317.21
cereal-----	317.20(D)
common name-----	317.56

Labeling: Continued

containers-----	317.3-317.9
contamination, sources of-----	317.10
cooked Salisbury steak, preparation-----	317.12(A)
corn syrup-----	317.20(G)
cracker meal, macaroni-----	317.20(I)
curing mixtures and seasonings-----	318.16
dehydrated celery, garlic, onions-----	317.20(F)
detailed requirements-----	317.1-317.66
fatbacks-----	317.20(H)
filing system-----	317.60
imitation sausage-----	317.39
in addition to Meat Inspection requirements-----	317.20(E)
ingredients:	
listing-----	317.20
order in which shown-----	317.57
inspection legend-----	317.2, 317.5
mark of inspection-----	317.36
master file in Washington office-----	317.37(A)
materials, acceptability of-----	317.11
meat byproducts-----	317.20(B)
meat mixture ratio, 70/30-----	317.20(J)
monosodium glutamate added to product-----	317.62-317.64
papain product from carcasses of animals	
injected with-----	317.66
Perishable, Keep Under Refrigeration-----	318.38
pork jowls-----	317.20(H)
pork shoulder picnic-----	317.14
product, common name-----	317.14
purpose of requirements-----	317.1
quantity of contents-----	317.29-317.31
rescinding labels-----	317.60
responsibility of inspector-----	317.59
sausage, vienna, containers-----	317.26
shortening-----	317.23
sliced cooked ham-----	317.12(B)
specific declaration required for ingredients	
certain products-----	317.20
stamped additions on approved labels-----	317.38
standards of composition-----	317.12, 317.13
submission-----	317.37(B)
supervision over-----	317.10, 317.11
terms acceptable regardless of anatomical	
derivation of meat-----	317.20(A)
tongues-----	317.20(A)
transparent wrappers-----	317.67
unskinned pork jowls-----	317.20(K)
visibility of product-----	317.67
weight-----	317.25-317.35

Laboratories:

cartons for samples forwarded to-----	318.73
identification of samples-----	318.70(G)
information supplied by-----	318.70(A)(C)
mailing samples to promptly-----	318.70(K)
plastic bags furnished by-----	318.70(I)
purpose-----	318.70(A)
reporting samples to-----	318.71
samples for examination-----	318.71-318.75
special handling of samples by Washington Laboratory-----	318.72

Lard:

refined, definition-----	317.51
residue incident to rendering-----	317.49(G), 317.50
Lead and lead seals, in contact with product-----	308.12(V)
Lead poisoning-----	311.25(D)
Lesions, resulting from antibiotic injection-----	311.22
Light bulbs, maintenance-----	308.12(L)
Lips, used in meat food products-----	318.51
Listerellosis, animals recovered from-----	311.9

Livers:

calf, designation-----	317.43
condemned, handling for fish food-----	314.6
horse, condemned-----	329.6
Liver sausage, term inaccurate for certain products-----	317.54
Livestock Sanitary Officials, communicable diseases, reports-----	322.1, 322.2, 322.6

Loaves:

cured meat, canning-----	318.85
definition-----	317.45
nonfat dry milk used in-----	318.17
nonfat dry milk or dried whey with other substances not acceptable-----	318.69
other than meat, preparation-----	318.85
trimmings used in-----	318.85
Local authorities, cooperation with-----	322.1-322.13
Luncheon meat, water or ice added to-----	318.47
Iye solutions, used to remove outer surface of vegetables-----	318.19

Lymph nodes:

extent of lesions-----	311.2
hog heads, abscesses-----	311.4
incision-----	310.7

Macaroni, labeling, declared as such-----	317.20(I)
Magnetic traps, use of-----	308.11
Malaysia, special export requirements-----	324.97
Manteca or Manteca Pura, use of terms-----	317.52
Market Cattle Testing Program-----	322.10
Market heads-----	310.15
Market sample tests-----	318.78

Marking:

artificially colored and similar statements-----	316.22
beef tenderloins-----	316.18

Marking: Continued

calf carcasses-----	316.16
carcasses-----	316.14
carcasses of animals injected with papain-----	316.36, 317.66
curing mixtures-----	318.16
cuts from carcasses of foreign origin-----	316.35
features other than inspection legend on shipping container-----	316.32
horse meat and containers-----	329.13-329.16, 329.18
hot-iron brands, legibility-----	316.9
immediate or true containers-----	316.31
ink, approved branding-----	316.10, 316.11
material submitted for approval-----	316.1
only legible imprints allowed-----	316.1
pencils and crayons-----	316.10, 317.4
shipping containers, rendered fat, inedible-----	316.34
(Also see Branding and Labeling)	

Materials:

other than meat or meat food products-----	318.76
satisfactory chemically but unsatisfactory in actual use-----	318.86
suitability determined by Washington office-----	318.12

Meat:

cured (See Cured Meats)	
declaration on label-----	317.20(A)

Meat byproducts:

containing large amounts of skin-----	318.7
included in sausage and other products-----	318.62
mettwurst, not permitted in-----	318.58
specific declaration-----	317.20(B)

Meat Grading Service:

estimation of survey costs-----	322.16
examination for non-federal agencies-----	322.7
identification of cattle-----	322.7
survey of non-federally inspected plants-----	322.15

Meat laws investigators, records of carriers to be checked by-----325.4

Melanin:

deposits of-----	311.11
inspection of horse carcasses when deposits found-----	329.11

Mercury-----311.25(D)

Mesenteric lymph nodes, swine-----310.10(B)(4)

Metal:

clips or staples, not permitted with labels or tags-----	316.20
restricted use of some-----	308.12(V)

Mettwurst, certain products not permitted in-----318.58

Mexico:

certificate, horse meat from-----	329.17
special export requirements-----	324.101

Mineral oil, application to sausage casings-----318.53

Moisture, content in sausage-----318.70(J)

Mold inhibitors-----318.53

Monosodium glutamate:	
added to pickle for cured meats-----	318.29
use in certain products-----	317.62-317.64, 318.60
Mucosal Disease Complex-----	322.6
Mules, term "equine meat" not applicable-----	329.1
Mustard, amount limited in sausage and meat loaves-----	318.63
Name of product to be true designation-----	317.56
National Animal Disease Laboratory, Ames, Iowa,	
specimens submitted to-----	311.6(A)
"Needle Grass," sheep carcasses affected with-----	310.10(D)(6)
Netherlands, special export requirements-----	324.105
Net Weight:	
determination of-----	317.32-317.35
expressed in units-----	317.25
(Also see Weight)	
New Zealand, special export requirements-----	324.109
Nitrates, acceptable ingredient-----	318.23
Nitrites:	
acceptable ingredient-----	318.23
commercial curing compounds containing-----	318.23, 318.83
decharacterized, use in cooking canned meats-----	318.48
entry into establishments-----	318.23
samples examined for-----	318.70(K)(2)
Nonfat dry milk:	
mettwurst, not permitted in-----	318.58
mixtures not acceptable-----	318.17
samples-----	318.70(B)
sausage and meat loaves, use in-----	318.17
unacceptable with other substances-----	318.69
Non-federally inspected plants, surveys-----	322.15
Norway, special export requirements-----	324.113
Odors, product suspected of having absorbed-----	318.2
Offal products, inspection of-----	310.10(F), 327.15
Oil, frying-----	318.91
Oil of cade, used to produce simulated smoke flavor-----	318.88
Oleomargarine, inspection of-----	328.1
Onions, listed in statement of ingredients-----	316.25, 317.20(F)
Organophosphorus-----	311.25(B)
Overweight tolerances-----	317.35(B)
Ozone, lamps or equipment producing, restriction of-----	308.15(C)
Packaging, unmarked product-----	307.1
Packing substance, not included in net weight-----	317.34
Pancreatic glands, sheep, no tapeworm infested glands to be used-----	310.14
Papain:	
carcasses of animals injected with-----	317.66
marking carcasses injected with-----	316.36
permissible for treatment of steaks-----	318.24
Paprika, added to products-----	316.25, 318.56

Paraffin oil, use of-----	308.15(H)
Parsley, specific declaration-----	317.18
Partially defatted beef and pork-----	315.6
Partially defatted beef and pork fatty tissue-----	315.5
Perishable, Keep Under Refrigeration, hermetically sealed, canned product-----	318.38
Permits:	
removal of diseased or condemned material-----	314.4-314.5
return of alleged unsound product-----	325.17
Pest control-----	308.3-308.5
Pesticides, exposure of animal to-----	309.5(D)(8)
Pet food, preparation in horse meat establishments-----	329.2
Pharmaceuticals, preparation not to interfere with edible products-----	310.10(F)
Phosphate:	
addition to pumping pickle for certain products-----	318.35
used in loaves-----	318.85
Pickle:	
addition of phosphate-----	318.35
corn syrup solids in-----	318.30
reuse of-----	318.30
Pickles, specifically declared as ingredient-----	317.18
Picnic, labeling-----	317.14
Pies, pizza, crusts or dough used in preparing-----	318.81
Pigments, affecting carcass disposition-----	311.11, 311.12
Pimento and Pimiento-----	317.18, 317.19
Pistachio nuts, specific declaration-----	317.18
Pizza crusts, certification required-----	318.81
Plastic films, samples of-----	317.11
Plasticizers, used with packaging material-----	318.86
Poland, special export requirements-----	324.119
Pork:	
boned heads, description-----	317.20(C)
boneless, shoulders or butts in casings, treatment for trichinae not required-----	318.15
canned, control of added substances-----	318.74
cured, control of added substances-----	318.74
cuts, ice glazed-----	318.9
fatbacks, declaration-----	317.20(H)
fats:	
rendered-----	317.49(G), 317.50
statement of ingredients-----	317.20(H)
jowls:	
declaration-----	317.20(H)
slicing of-----	318.6
unskinned, declared in statement of ingredients-----	317.20(K)
unskinned, permissible amount in various sausages-----	318.61

Pork: Continued

loins and chops, center cut-----	317.21
loins, cured boneless-----	318.31, 318.32
shoulder picnic-----	317.14
shoulder plate bacon-----	317.41
skins, fried, labeling-----	317.15
smoked, control of added substance-----	318.74

stomachs:

braunschweiger, not permitted ingredient of-----	317.54
considered meat byproducts rather than casings-----	316.19
trichinae, treatment to destroy-----	318.28
viscera separation-----	310.10(F)

Post-mortem inspection:

actual slaughtering time, recording-----	311.17
brucellosis reactors-----	310.10(A)(13)
calves-----	310.10(C)
cattle-----	310.10(A)
detailed requirements-----	310.1-310.16
disposition of unopened carcasses-----	311.13
enzyme reactions-----	310.13
hogs-----	310.10(B)
horses-----	310.10(E)
"on-the-rail" procedure-----	310.10(A)(2)
proteolytic enzymes, injection in cattle-----	310.13
reactors that have died otherwise than by slaughter-----	309.5(D)(4)
routine-----	310.10
sheep-----	310.10(D)
suspects-----	310.9
tagging carcasses-----	310.4
tuberculin reactors-----	310.10(A)(12), 311.5
viscera inspection-----	310.10(F)

Potatoes, dehydrated-----	316.25, 317.20(L)
---------------------------	-------------------

Potted and deviled meat food product:

water content-----	317.58
water-protein ratio-----	318.75

Poultry:

inspection on overtime or holiday basis-----	322.13
material used when performing inspection-----	322.12
slaughter-----	302.3(A)
use in meat food products-----	302.3(B)

Premises, facilities for ante-mortem inspection-----	309.2
--	-------

Preservatives, for various ingredients-----	318.68
---	--------

Pressings, definition-----	317.49(G)
----------------------------	-----------

Processing:

new methods, reporting-----	317.13
product transported for further-----	316.21
responsible supervision to be provided-----	318.11

Products:

accidental contamination-----	318.1
amenability to regulations-----	317.65

Products: Continued

beans, contained in-----	318.25
bones, ingredient of-----	318.14
canned, having minimum acidity-----	318.46
common name of labeling-----	317.14, 317.56
compliance with regulations-----	318.11
condemned and destroyed-----	318.4
contamination, sources of-----	308.12, 308.13
defrosting-----	318.3
farm-dressed, shipped interstate-----	325.15
glycerin not acceptable in-----	318.22
ice glazed-----	318.9
interstate transportation of federally inspected-----	325.1
lips from certain animals-----	318.51
market sample tests-----	318.78
minimum requirement for certain-----	318.70(C)
net weight, proper statement required-----	317.25
nitrates and nitrites-----	318.23
retail intact, sold at-----	316.23
shipment interstate in establishment or personally owned vehicle-----	325.7
shipping and receiving when inspector not on duty-----	307.1
soiled accidentally-----	308.15(A)
transportation via another state of nonfederally inspected-----	325.2
unmarked, shipped between official establishments-----	325.12
unsoundness, improper weight, adulteration-----	318.80
Protein, content in permissible spices and seasonings-----	318.63
Proteolytic enzymes:	
cattle injected with on post-mortem inspection-----	310.13
testing meat-----	318.24
Public Health Service:	
cooperation-----	322.14
Rail inspection:	
calves-----	310.10(C)(4)
cattle-----	310.10(A)(10)
hogs-----	310.10(B)(6)
horses-----	310.10(E)(4)
sheep-----	310.10(D)(3)
Railroad cars, cleaning and disinfection-----	322.9(B)
Reactors:	
animals that have died other than by slaughter-----	309.5(D)(4)
brucellosis, reporting-----	311.7
"Ready-to-Eat," pork products bearing statement-----	316.24(B)
Records:	
falsification of-----	323.1
instructions for sample-----	318.71
Rectum, to be tied:	
cattle-----	310.10(A)(8)
hogs-----	310.10(B)(3)

Red Dye No. 4-----	318.92
Reindeer:	
slaughter-----	302.2
use in meat food product-----	302.2
Reimbursement:	
blood samples collected for ANH-----	322.10
Rejection of materials-----	318.16
Rendering:	
carcasses and parts into lard, edible-----	315.1-315.4
sourness-----	315.2
Repackaged meat, foreign origin-----	316.35
Reports:	
Ante-mortem identification card-----	320.1
Ante-mortem summary-----	320.1
Ante-mortem and post-mortem inspection summary, MI-403-----	320.1
Application for export certificate and/or stamps, MI-412-----	320.5
changes in method of slaughter-----	381.2, 381.4
emergency work stoppage-----	305.3
establishment not eligible for inspection-----	302.1(B)
Label transfer form, MI-441-----	320.8
Label transmittal form, MI-442-----	320.9
Laboratory form, MI-422-----	320.6
loss of key or badge-----	306.2
Materials rejected for use, MI-407-4-----	320.4
Meat and meat food products condemned on reinspection, MI-407-----	320.3
Method of slaughter, MI-403-4-----	381.1-381.5
Notice of receipt of unclean or unsound product, MI-437-----	320.7
operations affecting inspection-----	302.5
slaughtering time-----	311.17
suspension of inspection-----	305.1
Residues, instructions for sampling-----	311.25
Retail butcher or retail dealer, exempted-----	304.3
Retail intact, products sold at-----	316.23
Rodent control-----	308.3-308.5
Rodenticides, to control vermin-----	308.5
Safety, instructions regarding-----	307.2
Salisbury Steak, cooked-----	317.12(A)
Salivary glands-----	317.22(C)
Salt:	
anticaking agent, approved quantities and kind-----	318.20(A), 318.82
clean and free from extraneous material, if in	
contact with product-----	318.20
equipment for preparing solutions of-----	318.20
handling to preclude soiling-----	318.20
solutions, preparation of-----	318.20
wetting cloths in solution of, for dressed carcasses-----	310.11

Salvador, special export requirements-----	324.127
Samples:	
ability particular laboratory to handle-----	318.70(E)
analytical results-----	318.74
blood collected for ANH-----	322.10
boneless meat-----	318.8
cartons and franks for forwarding-----	318.73
cereals, spices, and similar material-----	318.70(H)
chart for establishment procedures-----	318.74
check, for laboratory analysis-----	318.11
collection and shipping-----	318.70(F), 318.74
commercial curing compounds-----	318.22, 318.83
contamination, examination for-----	318.70(B)
controlling added substance-----	318.74
corned beef hash-----	318.90
cured meats containing monosodium glutamate or hydrolyzed plant protein-----	318.29
enzyme solutions-----	309.4
formalin added for certain products-----	318.70(K)(3)
Fruit and Vegetable Division assistance in drawing-----	322.11
identification of, preparation of-----	318.70
incubation of test-----	318.47
Labels, Standards and Packaging Branch-----	318.72(B)
lesions resulting from antibiotic injections-----	311.22
mailing instructions for perishable samples-----	318.70(K)(4)
mailing promptly-----	318.70(K)(1)
material used as containers-----	317.11
monosodium glutamate or hydrolyzed plant protein, amount in product-----	318.60
multiple-----	318.74
new products-----	317.12
nitrite, examined for-----	318.70(K)(2)
noncompliance with regulations-----	318.71(D)
plastic film bags-----	318.70(G)(I)
preparation and handling-----	318.70-318.75
procedures used in sampling-----	318.70(J)
records of-----	318.71(A)
reporting to laboratories-----	318.71
sausage-----	318.11(B), 318.70(J)
selection and submittal-----	318.79
special handling by Washington laboratory-----	318.72
spices and seasonings-----	318.63
taken when necessary-----	318.11
Sanitation:	
exclusion of flies and vermin from establishments-----	308.3-308.5
requirements-----	308.1-308.15
sanitizing agents, acceptable-----	308.2(B)
Sausage:	
added substance-----	318.62
added phosphate-----	318.62
added water in canned sausage-----	318.60

Sausage: Continued

cereal, equipment used for product containing-----	318.56
color penetration-----	318.67
condiments added to-----	318.55
cooked and not cooked, water added-----	318.59, 318.60
disposition of products not in compliance	
for added water-----	318.70(J)
dye-impregnated artificial casings-----	318.66
"farm" or "country" style-----	317.17
formalin added to prevent decomposition-----	318.70(K)(3)
gelatin not acceptable ingredient-----	318.21
grinder plates-----	308.13(A)
ingredients, certain products not acceptable-----	318.52, 318.60
nonfat dry milk or dried whey with other	
substances not acceptable-----	318.69
nonfat dry milk used in-----	318.17
packed at catch weights-----	317.30
pork jowls, unskinned, permissible amounts-----	318.61
preparation-----	318.67
prepared with meat byproducts to exclusion	
of meat-----	318.54
rework of "Blow-out sausage"-----	318.66
rework of collagen casings-----	318.62
samples for laboratory analysis-----	318.70(J)
sodium caseinate, adulteration with-----	388.18
soy bean derivatives as ingredients of-----	318.69
stuffing machine, care of-----	308.13(D)
temperature prior to canning-----	318.41
trichinae, treatment for destruction of-----	318.27
water or wine added when treated for trichinae-----	318.64

Sawdust:

hardwood, for smoking products-----	318.13
use restricted-----	308.12(Q)

Scales, accuracy of-----318.87

"Scotch style" hams, definition-----318.73

Scrap fat, definition-----317.49(D)

Sea food, handling in official establishments-----318.89

Sealed cars:

form for shipment unmarked product-----	325.12
report of nonarrival-----	325.11

Seals, official:

breaking without authority-----	325.8
company, use of-----	318.8
interstate transportation under-----	325.8, 325.9
wing, use of-----	318.8

Seasoning preparations:

amount limited in certain products-----	318.63
anticaking agents, acceptable as-----	318.82
approval and labeling-----	318.16

Seasoning preparations: Continued

content-----	318.26
mixed with material to produce smoke flavoring-----	318.88
soluble, prohibited use-----	316.25
Secondhand containers, inspection and cleaning-----	308.15(I)(J)(K)
Selenium-----	311.25(D)
Settlings, definition-----	317.49(F)
Sexual odor:	
disposition-----	311.19
labeling-----	311.19
shipment of affected meat-----	311.19
swine carcasses-----	311.19
Shankless ham, significance of term-----	317.48
Sheep:	
caseous lymphadenitis, detection-----	310.10(D)(4)(5)
heads, contamination of-----	310.10(D)(1)
post-mortem inspection-----	310.10(D)
rail inspection-----	310.10(D)(3)
viscera inspection-----	310.10(D)(2)
viscera separation-----	310.10(F)
washing carcasses-----	310.10(D)(1)
"Wild oats" or "needle grass"-----	310.10(D)(6)
Shipment, due notice to inspector-----	307.1
Shipper's certificates:	
horse meat-----	325.6
U. S. Inspected and Passed product-----	325.3
Shipping containers:	
applicable marks of inspection, combination of products-----	316.30
features other than inspection legend applied to-----	316.32
inedible rendered fat-----	316.34
marking, if also immediate or true container-----	316.31
Shortening, labeling-----	317.23
Shroud cloths, rinsing-----	308.15(F)
Shrouding, general requirements-----	310.11
Silent cutters, cleaning-----	308.13(C)
Sketches and labels, form for transmittal-----	317.37
Skimmings:	
definition-----	317.49(E)
from hog washings, inedible-----	310.10(B)(10)
Skinning, unborn calves-----	314.3
Skins:	
detached-----	317.49(A)
fried pork-----	317.15
meat byproducts, freedom from hair roots-----	318.7

Slack barrels and similar containers:	
contamination of product with wood splinters-----	308.12(D)
removal of cloth coverings-----	308.12(O)
Slaughter:	
animals other than cattle, calves, sheep,	
swine or goats-----	302.2
emergency, provisions for-----	309.5(D)(1)
poultry-----	302.3
Smoke and imitation smoke flavorings, suitability-----	318.88
Smoked additives-----	318.88
Smoked meats:	
declaration in list of ingredients-----	316.29
sausage, use in-----	318.62
Smoking:	
acceptability of certain wood-----	318.13
while employees on duty-----	308.6
Sodium caseinate, adulteration with-----	318.18
Sodium hydroxide, for processing vegetables-----	318.19
Solutions, injected into meat for curing-----	318.28
Soup bases and the like-----	318.77
South Africa, Union of, special export requirements-----	324.133
Soy bean derivatives-----	318.69
Soya flour, ingredient mixtures containing-----	318.69
Specification Examination Service:	
application for-----	340.4
charges for-----	340.5
Specimens:	
antibiotic injections-----	311.22
diseased tissues-----	311.14
lesions suspected of being tuberculous-----	311.6
reporting laboratory submission-----	311.14
research or educational-----	314.3-314.4
submitted to Pathology Laboratory-----	311.6(B), 311.14
Spices:	
amount limited in certain products-----	318.63
applicability of terms-----	317.16
approval and labeling-----	318.16
extractives, labeling-----	316.20
farm or country style sausage prepared with-----	317.17
protein content-----	318.63
Spitting on floor, prohibited-----	308.7
Sprays, to eliminate vermin-----	308.4(B)
Staining of product, by aluminum-----	308.12(G)
Standard Weight Sets-----	318.87
Staples or metal clips, use not permitted with	
labels or tags-----	316.20
State animal disease control officials, cooperation	
in reporting infectious diseases to-----	314.5

Steam, use permitted in smokehouses-----	318.13
Steel wool, use not permitted-----	308.12(H)
Stencils and box dyes-----	316.32
Stephanurus dentatus-----	310.10(B)(6)
Sterilizers and wash basins, maintenance and use of-----	310.1, 310.2
Stews, meat prepared for under Identification Service-----	340.1
Stockinets, use on labeled product-----	317.7
Stomachs, pork definition-----	316.19
Stuffing machines, cleaning-----	308.13(D)
Stunners, captive-bolt, used for cattle-----	310.10(A)(1)
Stunning devices, humane slaughter-----	380.1
St. Vincent Island, special export requirements-----	324.125
Sugar, amount in seasoning preparations-----	318.26
Supervision, operations not requiring-----	307.1
Supervisors, responsibility toward preparation of meat products-----	318.11
Suspects:	
animals recovered from listerellosis-----	311.9
melanin deposits-----	311.11
post-mortem inspection-----	310.9
report of disposition-----	311.15
Sweden, special export requirements-----	324.137
Sweet peppers-----	317.19
Swine:	
Anthrax encountered on slaughtering floor-----	310.16
hyperimmune, ante-mortem inspection-----	309.5(D)(6)
Switzerland, special export requirements-----	324.139
Tables, properly equipped-----	308.15(A)
Tags and tagging:	
carcasses on initial inspection-----	310.4
cattle heads and carcasses, identification-----	310.10(A)(2), 311.25, 322.4
ingredients, list of-----	316.26
Meat Grading Branch, identification of carcasses for-----	322.7
Tails, definition-----	317.49(B)
Tank cars:	
instructions for attaching MI Form 404-----	325.12
rendered animal fat transported between official establishments-----	325.10
Tanking:	
condemned product-----	314.1
equipment for inedible and condemned material-----	313.1
identifying marks or numbers on carcasses-----	314.1
recording information on daily form-----	314.1
rooms and tanks-----	313.1
Tapeworms, sheep pancreatic glands infested with-----	310.14
Temperatures:	
taking of-----	318.27
high and low thermometers-----	318.84
Temperaturing devices-----	318.37

Tender, branding of word on heated and smoked product-----	316.24(A)
Tenderloin, beef marking-----	316.18
Testicles, from bulls reacting to brucellosis test-----	311.8
Thermocouples, for taking temperature of product-----	318.27, 318.37
Thermometers:	
checked for accuracy-----	318.37
furnished by establishment-----	309.2
product heated to destroy trichinae-----	318.27
registering high and low temperatures, for checking-----	318.84
Threadworms, in hog tongues-----	310.10(F)(1)
Thuringer, cereal not permitted-----	318.37
Tongues:	
cattle, post-mortem inspection-----	310.10(A)(4)(5)
hogs, inspection-----	310.10(F)
pork, inspection for abscesses-----	310.10(F)(2)
sheep and lambs, labeling-----	317.43
specifically named-----	317.20(A)
threadworms in hogs-----	310.10(F)(1)
trimmings-----	317.22
Tortillas, used in preparing meat food products-----	318.81
Transportation:	
carriers, requirements published by-----	325.5
farm-dressed product, certification-----	325.15
general requirements-----	325.1, 325.18
horse meat-----	325.6
inspected and passed product, certification-----	325.1
interstate in establishment or personally owned vehicle-----	325.7
nonfederally inspected product via another state-----	325.2
shipping records to be checked-----	325.4
under seal-----	325.8, 325.9
Tricalcium phosphate, anticaking agent-----	318.82
Trichinae:	
Armed Forces, smoked hams for, treatment not required-----	318.35
boneless pork loins and loin ends, shipment-----	318.31, 318.32
heating pork to destroy-----	318.27
Scotch style hams, treatment not required-----	318.33
treatment of pork products for-----	318.15
water or wine added to sausage treated for-----	318.68
Trimmings:	
cheeks and tongues, tissues included under term-----	317.22
used in preparation of loaves-----	318.85

Tripe:	
beef, specifically declared-----	317.20(B)
not customary ingredient of chile con carne-----	317.53
Trucks:	
cleaning and disinfection-----	322.9(A)
unmarked or restricted product shipped under seal-----	325.8
True containers:	
labeling requirements-----	317.3-317.5
serving as shipping container-----	316.31
Tuberculin reactors, lesions found during examination-----	311.6
Tuberculin test, cattle-----	311.7
Tuberculosis:	
final inspection of retained hog carcasses-----	310.10(B)(8)
identification of animals affected with-----	322.5
laboratory location-----	311.6
laboratory submission-----	311.6
lesions-----	311.6
mesenteric lesions-----	310.10(B)(4)
nodes, term defined-----	311.2
reactors, improperly identified-----	311.7
reactors, to tuberculin test-----	309.5(D)(4)
reporting non-reactors-----	322.3
reports covering lesions-----	322.3, 322.4(B)
specimen preparation-----	311.6
Underweight tolerances-----	317.35(A)
Unmarked product, shipment for further processing-----	316.21
(Also see Products, Transportation)	
"U. S. Inspected Meat Packing Plants", information	
on equipment and facilities-----	307.3
Vats, reconditioning-----	308.15(K)
Veal cutlets, use of term-----	317.61
Vegetables, use of lye solutions-----	318.19
Vehicles:	
cleaning and disinfection-----	322.9
Venezuela, special export requirements-----	324.148
Vermin, elimination and destruction-----	308.3-308.5
Vesicular conditions, hogs-----	309.5(D)(8)
Vienna sausage:	
calculation of added water-----	318.59
weight requirements-----	317.26
Viscera inspection:	
calves-----	310.10(C)(3)
cattle-----	310.10(A)(9)
hogs-----	310.10(B)(4)(5)
horses-----	310.10(E)(3)
separation-----	310.10(F)
sheep-----	310.10(D)(2)
Visitors-----	306.1

Warehouses, approved-----	318.9, 340.1
Water:	
added to:	
luncheon meats and meat loaf-----	318.47
sausage-----	318.59, 318.60
excess added-----	318.74
Meat Inspection requirements for official establishments-----	308.1
nonpotable-----	308.1(C)
percentage in certain products-----	318.62
potable, approved supply required-----	308.1(A)
protein ratio, potted meat food products-----	318.75
restrictions on use in certain products-----	318.47
solvent for nitrate ingredient-----	318.65
Weight:	
canned meat food products-----	317.32, 317.35
casings, statement on-----	317.29
checking-----	317.33
determination of-----	317.32
expressed in largest unit-----	317.25
finished product-----	318.11(A)(5)
general requirements-----	317.25-317.35
gross and tare, in lieu of net-----	317.28
product packed at catch weights-----	317.30
sausage in 4-ounce cans-----	317.26
standard sets-----	318.87
tolerances-----	317.35
wrapping and packing materials-----	317.27
Whey, dried:	
preparation of loaves-----	318.18
unacceptable, with other substances-----	318.69
Wholesale cuts, need not be sealed-----	318.8
"Wild Oats," sheep carcasses affected with-----	310.10(D)(6)
Windpipes, definition-----	317.49(C)
Wine, added as flavoring-----	318.64
Wooden curing vats, reconditioning-----	308.15(K)
Work stoppage-----	305.3
Wrapping, statement of weight-----	317.27

PART 301 - DEFINITIONS

301.1 The definition for "animal" includes calves as well as older animals under the general heading "cattle."

PART 302 - SCOPE OF INSPECTION

302.1

A. The sale of meat and product to Federal Agencies (Army, Navy, V.A., etc.) is regarded as placing the establishment in the category of interstate business.

B. The Officer in Charge should report to the District Director those establishments in which no meat or meat food product is prepared and distributed in one of the following:

1. Transported in interstate or foreign commerce.
2. Shipped to other official establishments.
3. Sale to Government agencies.

302.2 The Officer in Charge may permit the slaughter of food animals such as buffalo, reindeer, and elk provided facilities are adequate and the handling of these animals does not represent a hazard to the meat products normally produced. With the exception of reindeer slaughtered under the provisions of Section 340, these animals are not subject to inspection and are not eligible to bear the mark of Federal inspection. However, meat from these food animals may be used in certain meat food products if it is sound and wholesome.

302.3

A. Slaughter and evisceration of poultry are permissible in an official establishment provided the facilities are adequate and there is no interference with the inspection. If a separate department is not provided for this purpose, the poultry slaughtering equipment may be in the same room with slaughtering equipment for cattle, calves, etc., but this activity should not be permitted in rooms where exposed meat or product is being prepared, handled, or stored.

B. Poultry products, including egg products other than shell eggs, intended for use as ingredients of meat food products are acceptable when identified as having been inspected for wholesomeness by the U. S. Department of Agriculture and when found to be sound and otherwise acceptable when presented as an ingredient. This would apply not only to egg products used in the preparation of meat food products but also to those used in federally inspected establishments to prepare nonmeat food items which would subsequently be used in an inspected meat food product. For those nonmeat items containing egg products which are not prepared in an inspected establishment and which are intended to be used as ingredients of meat food products, it will be required that the manufacturer certify that the egg products used were inspected for wholesomeness by the U. S. Department of Agriculture.

The acceptability of shell eggs will be determined by the inspector at the time of use. Also, the fact that poultry products have been inspected for wholesomeness when produced does not relieve the meat inspector of the responsibility of assuring that these products are acceptable when used in establishments under his supervision.

Poultry products that have not been inspected for wholesomeness by the U. S. Department of Agriculture shall not be used in the preparation of meat food products.

302.4 The boning of wholesale cuts does not constitute processing within the meaning of Section 302.1 of the Regulations. Wholesale cuts boned elsewhere than in an official establishment should be so handled that at least one mark of inspection remains legible on each piece of meat if the product is to move further in interstate or foreign commerce or if it is to be admitted into an official establishment. Grinding or chopping of meat is regarded as processing within the meaning of Section 302.1.

302.5 Each inspector is charged with responsibility to notify his official superior regarding operations affecting inspection in the establishment or parts of the establishment to which he is assigned.

PART 304 - APPLICATIONS FOR INSPECTION OR EXEMPTION:
RETAIL BUTCHERS, RETAIL DEALERS, AND FARMERS

304.1 District Directors have authority and responsibility for granting, suspending or withdrawing Federal meat inspection.

A. Grants of inspection.

1. Officers in Charge shall:

- a. Forward one copy each of the completed Form MI-401, Application for Federal Meat Inspection to the District Director, Technical Services Division, and Compliance and Evaluation Staff.
- b. Forward three or more copies of plant drawings to Technical Services Division accompanied by Form MI-423, Submission and Approval of Plans and Specifications.
- c. Determine compliance of completed facilities with approved prints. See 304.2 of the Manual.
- d. When grant of inspection is recommended, state in writing to District Director:
 - (1) That a certificate of water potability issued under the authority of the State Health Agency is on file.
 - (2) That a statement of acceptability of the plant sewerage system is on file issued under the authority of the appropriate State agency.
 - (3) How the assignment will be covered.
 - (4) That approved labels and brands are on hand.
 - (5) That facilities comply with approved drawings.
 - (6) That railroad siding is or is not available.
- e. Deliver the letter granting inspection to plant management.
- f. Inform the District Director immediately when inspection has been inaugurated.

2. Technical Services Division shall:

- a. Review drawings and specifications of plants and equipment to determine compliance with requirements.

- b. Approve or disapprove such plans after consultation with field and Washington Divisions when applicable.
- c. Return one set to the applicant and one to the Officer in Charge from which they were received.

3. Compliance and Evaluation Staff shall:

- a. Review all applicants for inspection and determine whether the applicant has a history of violations or alleged violations.
- b. Furnish District Directors with positive or negative findings relative to such determinations.

4. Administrative Staff shall:

- a. Issue establishment numbers to each District Director for assignment to applicants.
- b. Maintain up-to-date records of applicants and grantees.
- c. Publish a monthly revised list of establishments operating under a grant of Federal meat inspection.
- d. Distribute copies of grant letters to Washington Divisions and Staffs.

5. District Directors shall:

- a. Evaluate applicants for inspection and all information relative thereto.
- b. Inform applicants of establishment numbers reserved for them.
- c. Issue grants of inspection when appropriate over their signature.
- d. Notify Administrative Staff, MI Records Center, Chicago, and other appropriate government agencies as soon as inspection is inaugurated.
- e. Maintain official records relating to applicants and grantees, i.e., correspondence, forms, etc.

B. Suspensions.

1. Officers in Charge shall:

- a. Transmit letters from plant management requesting suspension of inspection to the District Director.

b. Deliver letter of suspension to plant management.

2. District Directors shall:

a. Upon written request from plant management, issue letters which shall state the effective date and the date of termination of the suspension.

b. Notify those listed in 304.1 A 5 d of this action.

c. Maintain official records relating to suspensions of inspection.

3. Administrative Staff shall distribute copies of letters suspending or terminating suspension to Washington Divisions and Staffs.

C. Withdrawal of Inspection.

1. Officers in Charge shall:

a. Transmit letters from plant management requesting withdrawal of inspection to the District Director.

b. Deliver to plant management letters from the District Director withdrawing inspection.

2. District Directors shall:

a. Issue letters withdrawing inspection when requested to do so in writing by responsible plant management.

b. In accordance with Section 305.5 of the Meat Inspection Regulations with concurrence of the Deputy Administrator for Consumer Protection.

c. Notify those listed in 304.1 A 5 d of this action.

d. Maintain official records relating to establishments from which inspection has been withdrawn.

3. Administrative Staff shall distribute copies of letters withdrawing inspection to Washington Divisions and Staffs.

304.2 Remodeling or new construction blueprints should be presented for approval in accordance with Section 304.2 of the Regulations and 304.1 of the Manual, and forwarded through the Officer in Charge. Drawings shall include plot plan, floor plan, plumbing plan, elevations, sections, and specifications. The Officer in Charge should determine whether they are fully informative so proper evaluation can be made and if the proposal complies with inspection requirements. Instructions for preparation of drawings are in Agriculture Handbook No. 191, U. S. Inspected Meat Packing Plants.

If changes are needed, the Officer in Charge should have them made before forwarding the drawings. If changes cannot be agreed upon locally, the Officer in Charge should forward the drawings to the Technical Services Division with his comment and recommendations. In the event drawings are received without such information from the Officer in Charge, they may be returned.

If the drawings amend or supersede previously approved drawings, the sheet or job number or both, and the date of approval should be given in the letter of transmittal.

A. Officers in Charge are responsible for: surveying proposed establishments to determine compliance with approved drawings and specifications and general readiness for inspection; surveillance of construction at official establishments involving plant enlargement or remodeling projects to assure compliance with approved drawings; and reporting the results of such surveys and observations to the District office.

Each Officer in Charge having the responsibility for determining whether a proposed establishment, additions to, or alterations at existing inspected plants are in conformity with approved blueprints and specifications should supply himself with at least the following:

A good scale rule for assistance in interpreting the drawings.

An accurate tape measure (preferably metal) for taking exact measurements of floor areas, rail heights, door widths, etc.

A soft colored pencil for noting deficiencies or deviations on the drawings.

A good light meter for accurately determining the footcandles of lighting provided in various places in the project.

The foregoing articles may be borrowed from the plant if they are not otherwise readily available.

B. Before beginning the survey, the inspector should carefully read the specifications accompanying the drawings and become familiar with the general floor plan and other important features such as rail heights, type of ventilation, etc., illustrated in the blueprints. Some of the most important standards to be met are often included only in the specifications. These include such items as the screening of windows, details of potable water supply and sewage disposal systems, trapping of floor drains, and construction of equipment.

Inspectors should fully understand the various symbols used by draftsmen to indicate such details as windows, doors, overhead rails, refrigeration units, skylights, supporting columns, and floor drains. He can obtain assistance in a proper interpretation at most plants from engineers or other personnel.

C. In conducting the survey, inspectors much check for conformity with drawings by actually measuring important items such as ceilings and rail heights; spacing of operations in slaughtering department; door widths; distances between a plumb line from overhead rails and adjacent foot platforms, columns, or walls; and spacing of fixed pices of equipment in relation to the wall.

Location of floor drains and the pitch of floors toward the drains; number, type, and location of hand-washing facilities (including liquid soap; individual towels, and used towel receptacles); and hot and cold water hose connections should be carefully noted and checked against the drawings and specifications as should the type and location of all major pieces of equipment.

The facilities in the employee's welfare rooms and the inspector's office should be examined and a determination made as to whether they are as illustrated or described in the drawings and specifications and whether the facilities are adequate for the number of employees at the plant.

The adequacy of ventilation in all nonrefrigerated work areas and welfare rooms as well as the adequacy of the facilities for maintaining refrigerated work spaces at the temperature designated on the drawings should be determined.

It should be definitely established whether the water supply is adequate in volume and properly distributed in the plant. In those places requiring hot water at a specific temperature, a check should be made to see if such requirements can actually be fulfilled.

The outside premises should be examined to determine if such items as hard surfaced roadways; paved vehicular areas; paved, drained, and curbed livestock pens (equipped with suspect pens and squeeze gate, artificial lighting, cleanup hose connections, etc.); paved areas around catchbasins; and the like conform to the approved drawings and specifications.

Obviously the above does not cover all points to be considered in the course of a survey but is intended as a reminder of some of the more important aspects. The foundation for the proper conduct of operations and inspection is a properly constructed and equipped plants, and Officers in Charge must give adequate attention to surveys in order to assure that proper facilities are provided.

D. The inspector should keep a good set of notes regarding the deficiencies or deviations. After completing the examination of the project, the inspector should make a full written report to the company regarding such items, listing specifically and in detail those changes and/or additions required before the facilities will be accepted. The plant should inform the Officer in Charge when the corrections have been completed so that another survey can be made. A copy of the inspector's report should be forwarded to the Technical Services Division and to the District Director

The use of new or remodeled departments should not be allowed until the facilities are in accord with the approved plans in all important respects.

If certain minor deficiencies from the approved drawings and specifications are noted, such as a slight relocation of a lavatory, hot and cold water hose connections, or a piece of equipment that does not interfere in any way with the efficient utilization of the facility, the proper conduct of inspection, or the proper sanitary maintenance of the department, Officers in Charge may accept such deviations at their own discretion. All other items of nonconformity must be corrected or cleared with the Technical Services Division before acceptance.

When proposed plants are being readied for inspection or when major enlargements of existing plants involving a probable increase in production or inspection requirements are under construction, Officers in Charge should work out with the District Director plans for furnishing the necessary inspection personnel.

304.3 The name of each tenant operating in an official establishment, the scope of his operations, and a description of the part of the premises which he occupies should be forwarded in writing by a responsible official of the firm to which inspection has been granted, through the Officer in Charge, to the Technical Services Division. Information covering changes of the status of such tenants must be forwarded in a like manner. The owner or operator of the official establishment holding the grant of inspection is responsible for all operations in the establishment, including those of any tenant insofar as they affect the maintenance of inspection.

304.4 When blueprints contain numerous paster drawings, the Officer in Charge should request the establishments to provide blueprints or drawings incorporating all the information contained in the various paster drawings so that the old drawings may be removed from the files.

304.5 Officers in Charge should review blueprints at least yearly. When new projects have been completed, the Technical Services Division should be notified promptly by Form MI-423. When approved drawings are superseded by new or changed approved drawings, those superseded should be removed from the files and destroyed.

304.6 Officers in Charge should be sure that blueprints of drawings submitted for approval are in strict accordance with instructions contained on pages 2 and 3 of Agriculture Handbook 191, U. S. Inspected Meat Packing Plants. However, if the revision consists of paster drawings and the management of the establishment is unable to submit his previously approved master drawing, the Circuit copy should be forwarded with a request that it be returned after microfilming.

These requirements are waived for plants for which inspection is pending since drawings are not microfilmed until after inspection is inaugurated.

304.7 Approved drawings that are five years old for plants in which inspection has not begun are deemed out of date. Other projects are abandoned. Officers in Charge should ask the owners for a letter as to the disposition to be made of the drawings (return or destruction). A copy of the reply should be sent to the Technical Services Division. If the drawings are to be returned, this may be done without further instructions from Washington after obliteration of the marks of approval. This same procedure should be applied to drawings that have been on file five years after withdrawal of inspection.

304.8 When inspection is inaugurated at an establishment, the management and their employees are usually unfamiliar with the Meat Inspection Regulations and operating procedures of the program. They require additional guidance and supervision; therefore, arrangements should be made to provide additional inspection coverage so that effective application of the program is achieved as soon as possible. The necessary coverage will vary considerably between stations and between establishments. The Officer in Charge and the District Director must decide how much extra coverage is needed and for how long.

304.15 Whenever a new application for inspection is necessary because of a change of ownership, change of name, change in form of organization, or change in location, the effective date of the change should be specified either on the application or in an accompanying letter. An application for Federal meat inspection and the grant of inspection serves to identify the party that is to be held responsible for the maintenance of satisfactory conditions and compliance with the Meat Inspection Regulations at the establishment. A change in ownership must be recorded with the Meat Inspection Program, Washington office as soon as practicable.

The three usual types of parties involved in grants of inspection are an individual, a partnership, or a corporation. When the business of an individual is purchased or otherwise transferred to another party, the change in management calls for a new application by the new management. When there is a change in partnership involving any of the partners, the result is a new partnership and a new application is required. So long as a corporation as originally incorporated continues in control of an establishment, changes in the ownership of the shares of the corporation or a change of officers do not effect a change in the identity of the party (the corporation) in control of the establishment, and a new application is not necessary.

A. If a new corporation is formed to take the place of the one to which inspection is granted, a new application is required.

B. If the business of an individual or a partnership is taken over by a corporation, a new application is required.

C. If a corporation is liquidated and the assets are taken over by an individual, a partnership, or another corporation, a new application is required.

The control of the establishment, as mentioned above, has reference to the control of the business on the premises without reference to the ownership of the premises, which may be vested in another party altogether, in which case the party controlling the business at the establishment usually exercises authority over the premises by virtue of a lease from the owner.

When there is to be a change in the ownership at an establishment that requires a new application for inspection, it should be accompanied with a request from the management holding the current grant for withdrawal of inspection which is in its name. The date on which the transfer is to take effect should be given.

PART 305 - OFFICIAL NUMBERS AND INAUGURATION
OF INSPECTION

305.1 The Officer in Charge should advise the District Director whenever operations are suspended at an establishment. This report should include the reasons for, and length of, the inactivity if obtainable, and the disposition of inspection personnel. If the establishment is inoperative for a sufficient period of time, a letter of suspension of inspection will be executed by the District Director. When advised of this action, the Officer in Charge should make a review of the establishment and make a written report of conditions requiring correction before inspection is reinstated. A copy of his findings should be given to establishment management and the District Director.

305.2 The grant of inspection is forwarded to the Officer in Charge; he or a subordinate should deliver the grant to a responsible official of the establishment.

305.3 It is imperative that Officers in Charge report immediately to their District Director any emergency at the Circuit, such as strike, flood, or fire, which might result in a work stoppage. The report should be made in accordance with the requirements in C&MS Instruction 305-5.

PART 306 - ASSIGNMENT OF DIVISION EMPLOYEE

306.1 Access to a federally inspected meat packing establishment is a right guaranteed to those inspectors assigned to that establishment. This also applies to those other places such as docks and warehouses where inspection is performed. Persons other than assigned inspectors must be regarded as visitors and are admitted when it is acceptable to plant management.

306.2 The official badge should be worn over the left breast on the outer clothing of each employee assigned to ante-mortem, post-mortem inspection and the supervision of processing operations while these duties are being performed. The keys that are issued to the inspector should be kept on his person at all times. Badges or keys becoming unservicable, lost or damaged should be immediately reported to the supervisor and handled in accordance with C&MS Instruction 262-1.

PART 307 - FACILITIES FOR INSPECTION

307.1 "Due Notice" to the Officer in Charge regarding shipment of product from an official establishment will be worked out locally according to the needs of the establishment as well as that of the inspection service. When the Officer in Charge knows that the operating practices at an establishment meet acceptable standards, he may permit shipping and receiving of U. S. Inspected and Passed product during hours when an inspector is not on duty, subject to occasional unannounced checks. He may permit breaking of carcasses into quarters or primal cuts each bearing the mark of inspection. Unmarked product should be packaged and labels bearing the marks of inspection applied only while an inspector is on duty.

307.2 Supervisory inspectors will advise employees on matters relative to personal safety and the control and prevention of accidents. Division employees are not expected to initiate safety programs involving the employees of official establishments, but Division employees in supervisory capacities should include attention to safety factors when giving advice to establishments concerning plant facilities.

307.3 Information on equipment and facilities for the sanitary conduct of operations and inspection should be obtained from the pamphlet, "U. S. Inspected Meat Packing Plants."

307.5 The adequacy of lighting at inspection points should be determined by use of a light meter. The following minimum lighting intensities should be supplied before inspection is performed:

A. General Ante-Mortem Inspection. Ten foot-candles in the pens, alleys, or area where ante-mortem inspection is actually performed. Readings are taken three feet above the floor.

B. Suspect Pen. Twenty foot-candles over the entire suspect pen. If restraint facilities are separate, 20 foot-candles over these. Readings are taken three feet above the floor.

C. Head Washing Cabinet (Beef). Fifty foot-candles at the level of the head hook.

D. Beef Cervical (Head Rack). All areas of head illuminated to 50 foot-candles down to the symphysis of the mandible.

E. Beef Cervical (Head Chain). Fifty foot-candles at the lowest inspection point on the hanging heads.

F. Swine Cervical. Fifty foot-candles at the level of the mandibular lymph nodes of the lowest hanging heads.

G. Beef Viscera (Truck). Fifty foot-candles with meter resting at bottom of the pan of lower portion of truck.

Section 307.5

H. Viscera (Moving Top Table). Fifty foot-candles with meter resting in pan or on table top. (All species)

I. Rail Inspection. Fifty foot-candles at level of the shoulders. (All species)

J. Final Inspection. Fifty foot-candles at shoulder level, viscera pan, and head rack. (All species)

K. Carcass Coolers. Ten foot-candles at level of front shank of carcasses in cooler. Requirement does not apply to hot carcass coolers unless they are also used as a carcass holding cooler.

L. Offal Coolers. Twenty foot-candles general cooler illumination at lowest level of open product storage. Fifty foot-candles at packing point and reinspection area.

PART 308 - SANITATION

308.1

A. Officers in Charge are expected to assure that potable water from an approved supply is used in edible products departments and in associated areas.

B. Before the water supply is accepted, full consideration should be given to its source and the distribution system within the plant.

1. Generally, water from an approved public supply may be regarded as acceptable as delivered to the establishment. However, it should be sampled annually to check on possible contamination after delivery to the establishment.

2. When the establishment uses a private water supply, a report on the bacterial quality of the water taken inside the plant should be required at least every six months or at any other time the inspector has reason to question the condition of the water. The report should cover an examination of water, taken at a location specified by the inspector and examined by the local health agency having jurisdiction over the water supply in the area at the request of the establishment.

C. Water may become nonpotable as it is distributed in the plant. Therefore, inspectors should give regular attention to the condition of all storage facilities and pipelines in the establishment. Hazards such as dead ends of pipelines, improper cross connections between potable and nonpotable water and the absence of anti-back siphonage devices should be eliminated. Where use of nonpotable water is permitted for certain purposes, its use must be accompanied by adequate safeguards to assure that it cannot possibly come in contact with edible product or pollute the potable water supply.

308.2

A. Control over the use of cleaners, sanitizers, water treatment compounds, pesticides, hog scalds, tripe denuders, and sewage and offal chemicals will be handled by the inspector at the time of delivery of these materials into the plant. These labeled materials must be shown in the "List of Chemical Compounds" booklet. Materials which are not listed should be rejected unless the seller or establishment has a letter of approval from the Laboratory Branch of the Technical Services Division. Approval letters are intended to permit use of materials accepted during the interim between revisions of the booklet. Therefore, letters dated prior to the date of the current booklet should not be honored.

The procedure for getting compounds approved is shown on page 3 of the booklet.

The appearance of a compound in the booklet is assurance that it is chemically acceptable for use as indicated. The practical use of it is the responsibility of the inspector.

If there is any question concerning a material listed in the booklet, a sample of it should be sent to the Laboratory Branch, Technical Services Division, Consumer and Marketing Service, U. S. Department of Agriculture, Box 348, Beltsville, Maryland 20705.

Materials such as paints, lubricants, and other miscellaneous preparations which are not listed in the booklet and which do not belong in categories A to Z may be used provided the inspector has sufficient information to assure safety and usefulness of them. If such information is not available, samples should be submitted to the appropriate laboratory.

B. Sanitizing agents must not be used as a substitute for thorough and effective cleaning. Residues must be removed from edible product equipment by thorough rinsing with clean water before the equipment is again used for handling product. However, residues of the compounds need not be washed from floors, walls, and ceilings unless, in the judgment of the Officer in Charge, the presence of such residues is objectionable.

The strength of the solution of quarternary ammonium compounds customarily used does not exceed one ounce of the 10 percent aqueous solution, or one-tenth ounce of the dry chemical to four gallons of water. Avoid bringing the concentrated solution or the dry chemical into contact with the eyes or nasal passages because of the extremely irritating effect on mucous membranes. Solutions of sodium hypochlorite and chloramine customarily used do not contain more than one-half of one percent available chlorine (5,000 parts per million).

Solutions containing approximately 50 ppm of chlorine, iodine, or quarternary ammonium compounds may be used as a rinse, after washing, for the hands of employees handling meat food product. Solutions containing approximately 200 ppm of chlorine, iodine, or quarternary ammonium compounds may be applied to equipment which comes in contact with meat or meat food product. It will not be necessary to remove product from the room when these solutions are used but care should be taken to avoid contact with the product. Equipment should be rinsed with clear water following the use of such solutions. However, rinsing of employees' hands should not be required. Sodium hypochlorite and Iodophors (aqueous solutions of iodine and certain types of nonionic wetting agents) may be used to produce the chlorine and iodine, respectively.

Use of the sanitizing material should not be permitted to interfere with thorough washing and cleaning of equipment and employees' hands whenever necessary. The beneficial effects of using a sanitizing solution will not be obtained unless the area used is thoroughly cleaned.

Preparations of quarternary ammonium compounds and those of high available chlorine content, such as HTH, chloramine T, dichloramine T, and chlorinated cyanuric acid, should not be stored or used together since such handling may cause fires.

308.3 Elimination and destruction of insects and rodents in and around meat packing plants is vital to good sanitation. Two principles should be followed: Prevent their breeding; and prevent their entrance into establishments. In nearly all cases the owners of adjoining properties and the local health authorities will cooperate in developing a program for insect and rodent control. The management should obtain such cooperation. Any place that will afford food, water, and a hiding place is a potential source of pests. The most common places are manure piles, trash piles, garbage dumps, accumulations of paunch and stomach contents, and hog hair. Regulations do not permit such accumulations on the premises of official establishments. The cooperation of the local health authorities should be solicited by the management in eliminating such breeding places from the vicinity of meat packing plants.

Buildings and equipment that harbor pests should be repaired or replaced so as to eliminate breeding and hiding places. Walls, floors, and ceilings that have been tunneled by rodents should be replaced with rodent-proof material, such as concrete or brick. Tunnels may be blocked with 17 gauge hardware cloth, glass, metal, or other rodent-proof material. Stone and brick walls should have the joints pointed up flush and smooth, and all cracks, crevices, and openings around pipes, etc., should be sealed tight. Walls, ceilings, and partitions should be of tight-fitting material that will not permit the entrance or hiding of cockroaches and other pests. Floor drain strainers should be in good repair and should remain in place so as to prevent the entrance of rats through drainage lines. Dressing rooms and lunch rooms should be equipped and maintained so as to eliminate any breeding or hiding places.

Lockers should be examined regularly by the management and inspectors to see that they are kept clean and free from pests. Overcrowding (more than one person to a locker) should not be permitted, since it is difficult to keep overcrowded lockers clean and free from cockroaches. Dry storage rooms should be kept neat and clean. The stored material should be arranged so that as the supplies are moved the area can be thoroughly cleaned. Most dry stores can be placed on racks having a clearance of at least 12 inches from the floor and so arranged that the floor beneath the racks can be readily cleaned. If racks are not used, the dry stores should be closely piled so as to eliminate any possibility of runways or harborage for rodents. All openings that may admit rodents, birds, flies, and other pests should be effectively screened.

When pests do gain entrance to official establishments in spite of vigorous attempts to keep them out, certain eradication methods are permitted. This is an indication that the preventive measures have not been entirely successful and the management and inspectors should determine where they have failed and act to prevent a recurrence. It takes ingenuity to cope with all of the various kinds of insects and rodents. The goal of complete eradication of pests in official establishments is definitely possible and this goal should be attained.

308.4 Following is a description of permitted methods for the control of insects and rodents by the use of chemicals:

A. Fumigants.

1. Hydrocyanic Acid Gas. Fumigation with this gas is effective for most types of insects and rodents. Since this gas is extremely poisonous to man as well as to insects and rodents, permission for its use must first be obtained from the Officer in Charge and a competent, experienced person must be placed in direct charge of operations. Certain foods absorb the gas; therefore, when foods other than meat are to be exposed, prior permission for the fumigation should be obtained from the local health authorities. Exposed meats or packaged meats need not be removed from the rooms being fumigated. After fumigation the rooms should be well ventilated and tested by a skilled fumigator before inspectors or workmen enter the rooms. Ventilation must also be sufficient to assure complete removal of the gas from the surface of food products. Hydrocyanic acid gas may also be employed to eradicate mites, skippers, ham beetles, and the like from infested hams and similar products. Follow this by removal and condemnation of infested meat.

When liquid hydrocyanic acid is used, the equipment for releasing the gas should be so constructed and controlled as to positively prevent any of the liquid hydrocyanic acid from contaminating any product, and only the gas should be permitted to escape from the fumigating equipment.

2. Methyl Bromide Gas. Fumigation with this gas is permitted on the same basis and with the same restrictions as were set forth for hydrocyanic acid gas.

B. Insect Sprays.

1. Warning! Sprays containing some of the organic thiocyanates are quite toxic to animals and man, and when absorbed through the skin, ingested, or inhaled may cause serious illness. It is therefore considered wise for employees engaged in this work to wear properly designed masks to prevent inhaling the spray and clothing that will prevent contact of the chemical with the skin.

2. The residual action of DDT, chlordane, lindane, malathion, and more concentrated solutions of some other insecticides is usually effective against flies and the use of these solutions around the outer premises and inedible products departments has been satisfactory. A liberal application of these preparations on fences, the walls of the scale houses, inedible products loading docks, boiler rooms and the like, affords opportunity for flies attracted to the establishment to come in contact with the insecticide material and be killed before they can enter edible products departments. By contrast with this satisfactory use of insecticides, their application to walls, ceilings, and equipment in rooms where exposed meat or product is handled should not be permitted. The deposit of insecticide cannot be readily removed and continues to act rather slowly against flies or other insects which when overcome or killed may fall into the product. As the action of the

insecticide is continuous, there is no practical way to protect the exposed product from contamination with dead insects. Therefore, the use of these insecticides is limited to places where exposed meat is not handled.

3. So-called "knockdown" sprays containing pyrethrum or allethrin do not have a residual killing action and may be used in places where exposed meat is to be handled according to the restrictions outlined above. As these insecticides act very quickly, it is possible to kill all the flies in the room and with a minimum of labor wash down the excess insecticide and any flies that have been killed, before exposed meat is brought into the room. This use of the "knockdown" sprays, in addition to the application of residual insecticides in the manner already outlined, should control flies on premises that are kept clean and free of fly-breeding places.

4. The use of one and one-half fluid ounces of emulsifiable 50 percent strength malathion added to five pounds of granulated sugar and thoroughly mixed with a small amount of coloring (blue or green) to give a distinctive color to the mixture is a very satisfactory bait material around livestock pens and inedible departments of official establishments. Care should be taken to place the bait so that it cannot be ingested by livestock.

5. Colored sugar baits (blue or green) containing one to two percent of either Diazinon or Dipterex have also been used effectively for fly control in these areas.

6. Deodorized kerosene solutions of pyrethrins or allethrins or a combination of the two containing not more than one percent of piperonyl butoxide may be used in the form of an aerosol in all departments, in accordance with the restrictions applicable to pyrethrum extracts.

7. Solutions containing more than one percent of piperonyl butoxide, N-propyl isome, and N-octyl dicycloheptane dicarboximide (MGK 264) and solutions of chlordane, lindane, methoxychlor, and malathion with or without other approved insecticides may be used with the limitation applicable to DDT; that is, outside edible products departments.

8. Allethrin is acceptable on the same basis as pyrethrin, that is, in deodorized kerosene solution or other approved carrier.

9. N-propyl isome is acceptable on the same basis as piperonyl butoxide.

10. N-octyl dicycloheptane dicarboximide (MGK 264) is acceptable on the same basis as piperonyl butoxide.

11. Insect repellents containing di-n-butyl succinate as the active ingredient are effective around loading docks, door and window facings, and similar areas of official establishments.

C. Insect Powders.

1. Any of the dry insecticidal compounds listed when mixed with dry inert material are acceptable for use as an insect powder in accordance with the restrictions applicable to the same insecticide when used in insect sprays.

2. Sodium fluoride, powdered pyrethrum, rotenone, borax and boric acid, and powders containing organic thiocyanates or DDT in an inert base may be used for the elimination of cockroaches under the same restrictions governing the use of sprays. With the exception of powders that possess a definite brown color, all powders shall be definitely colored blue or green.

D. Rodent Baits.

1. Anticoagulants. Rodent baits composed of Warfarin, Pival, Fumarin, Diphacin, PMP, or Prolin and cracked cereal grains or blue or green colored cereal of other vegetable meals or flours may be used in edible departments provided the layout has been approved by the Officer in Charge and the bait is contained in boxes plainly marked "RODENT BAIT." For proper adherence, cracked cereal grains should be thoroughly mixed with enough melted animal or vegetable oil to lightly coat each particle before the addition of the anticoagulant. This will require approximately two ounces of oil to five pounds of grain. Each bait box will be marked with a serial number and the name of the firm or individual responsible for the rodent control. Bait boxes will be so constructed that all sides, top and bottom are capable of being closed and fastened leaving only openings for the free entrance and exit of rodents. Aqueous solutions of anticoagulants may be used in drinking fountains similar to those used in the poultry industry provided the solution is colored green and the fountain marked and used in bait boxes of the same type and markings as described above. Bait boxes and bait boxes containing fountains for dispensing dry and liquid anticoagulants may be allowed to remain continuously in departments having a dry cleanup so long as the need exists and the box does not become a nuisance. Bait boxes placed in areas having a wet cleanup must be placed after the cleanup and removed to an acceptable dry area prior to the beginning of operations. Anticoagulants produce internal hemorrhages in rodents and other warm-blooded animals and must be eaten over a period of 2 to 10 days to produce a lethal effect. The physiological action of these chemicals is similar to that of the dicumarol widely used in medicine as an anticoagulant for blood. It must be remembered that bait boxes within the building of an establishment are a means of eliminating rodents as opposed to controlling rodents. Control should be accomplished by rodent proofing buildings and maintaining a rodent-free zone around buildings.

2. Red Squill. This substance mixed with proper bait is highly toxic to rats. Baits shall not be placed in edible products departments until after operations have been ended for the day. All uneaten baits must be gathered up and destroyed before operations are begun the next day. Baits must not be placed in dry salt cellars. They may be placed in other departments containing exposed meats, but care must be taken that they are so placed as to prevent contamination of the meat.

3. Tracking Powders and Sticky Boards. Tracking powders colored blue or green and sticky boards, may be used in departments having a dry cleanup, provided there is no exposed product in the department. Sticky boards may also be used in departments having a wet cleanup, provided there is no exposed product and that the sticky boards are placed after the cleanup and removed prior to beginning of operations. Neither tracking powder or sticky boards shall be used in a manner to create a nuisance.

308.5 Storage and Use of Insecticides and Rodenticides. Insecticides and rodenticides when stored in official establishments shall be in a location acceptable to the Officer in Charge and shall be under the supervision of a responsible establishment employee. When used by an establishment employee, the use including preparation and placing of baits must be under the direct supervision of a Program inspector. When used by other than an establishment employee, these materials shall be used only by pest control operators licensed by the state in which they operate. No condition that may be a source of danger to human health or that is not consistent with proper sanitation or inspection should be permitted to develop.

308.6 Personnel—Dress—Conduct. Program employees must not smoke while on duty or while in rooms where meat or meat product is prepared or handled. Establishment employees must not be permitted to smoke while working with exposed product. If the management of the establishment has restrictions pertaining to smoking, such requirements should also be observed by Program employees.

308.7 Spitting on the floor should be prohibited.

308.8 All employees working in departments where exposed product is handled should wear head coverings to prevent hair from falling into the product.

308.9 Leather aprons, wrist guards, and the like used as safety devices for employees engaged in cutting or boning meat must be maintained in a clean and sanitary manner. To assist in maintaining leather aprons in satisfactory condition, a clean, washable cloth covering may be worn over the apron.

308.10 Wearing of badges, identification cards, campaign buttons, and similar articles on outer clothing by persons who handle products should be discouraged. However, similar articles necessarily worn must be so attached that their accidental inclusion in product will be definitely precluded.

308.11 Contaminants—Foreign Material. Magnetic traps have been found effective in removing iron particles from chopped meat products. They should not be used as a substitute for proper inspection procedures.

308.12 The following possible sources of contamination are given to aid inspectors in carrying out their responsibility to prevent contamination of product:

Section 308.12(A)

A. The edges of shovels should be ground as often as necessary to prevent the rolling edges from crumbling into product. Cast alloy shovels made of the softer metals require close attention.

B. Staples from metal stitching machines represent a dangerous source of contamination. Operation of the machines near open containers of product should not be permitted. Metal-stapled containers and wirebound boxes of product should be opened with great care.

C. Metal tag fasteners used to apply numbered identification tags in the slaughtering departments should be removed after they have served their purpose. Other metal tag fasteners, tags, wood and metal skewers, etc., should be completely removed from carcasses prior to cutting or boning. Tag fasteners that cannot be readily removed from the meat should not be permitted.

D. Care should be exercised in opening slack barrels and other containers closed with nails to see that nails and wood splinters do not enter the product.

E. Attaching paper or burlap barrel covers by means of small staples is not permitted.

F. Worn can openers, metal cut by friction, broken or worn parts of equipment, wire used to suspend overhead equipment, loose hooks on cooler racks, metal strapping from fiber containers, and broken wire from bacon hangers and belly spreaders are all sources of metal contamination which should be given careful attention.

G. Staining of product through contact or friction with aluminum can largely be avoided by the use of anodized aluminum hooks, rails, pipes, and sheets. The anodic coating may erode in time and anodizing becomes necessary to prevent contamination of product. Use of hard metal hooks, such as galvanized iron or stainless steel or aluminum rails may cause abrading of the rail surface and deposit of small particles of metal on the product.

H. Fine wire brushes or steel wool should not be used on product, or on equipment that will come in contact with product.

I. Metal trucks and equipment that have been welded should be carefully examined to see that they are free from metal beads and pieces of slag before being used.

J. Frequent examination must be made of multiple needle pickle-injecting equipment. When a needle is missing from the device, a diligent search must be made until the broken needle is located or accounted for.

K. Enamelware is not acceptable.

L. Unprotected light bulbs should not be suspended directly over choppers, grinders, mixers, and similar equipment. Burned out light bulbs should be placed in rubbish containers immediately on removal from the

electric fixture. Special care should be given to the disposal of fluorescent tubes which may contain a poisonous gas. Such tubes should not be broken in an edible products department of the establishment. Milk, beverage, and other glass bottles should not be permitted in processing departments. Broken or cracked window panes should be repaired promptly.

M. Scaling paint, dust, and flaking rust must be scraped from overhead structures in edible products departments. Condensation should not be permitted. Condensation can be effectively controlled by circulation of heated air in nonrefrigerated rooms. In coolers, insulation of walls or ceilings or the application of heat by means of very small steam lines near the ceiling will control condensation without seriously interfering with refrigeration.

N. Inspectors should assure themselves that containers and coverings for product, including metal lard drums which may have a coating on their inner surface, are acceptable for use. Slack barrels and similar containers should be carefully examined for wood splinters and lined with suitable material to avoid contamination with splinters. When paper is used to line containers, it should not disintegrate when in contact with meat and juices. All paper adhering to the outer surface of frozen blocks of meat should be removed before the blocks are cut. In some cases, copper coated staples have been used in fiber containers. When in contact with meat, these staples cause a green discoloration which should be removed prior to use of the product.

O. In opening burlap or muslin-covered slack barrels care should be taken to completely remove the cloth covering before puncturing the protective paper covering under the cloth.

P. Cloth, paper, or other containers of meat products or of ingredients such as sugar or spice should be dumped in such a manner that lint or dirt on the outer surface will not contaminate the product.

Q. Sawdust should not be used on benches or equipment or on floors in areas where operations such as grinding, boning, or cutting are being done. Sawdust used on floors of coolers must be clean and free from objectionable odors and should be replaced daily. Only a very thin covering should be used.

R. Walls or posts constructed of masonry materials should be protected by suitable guardrails.

S. In some elevator shafts moisture from the threshold of the floor above frequently falls into the trucks of meat being moved on or off the elevator at the lower levels. A method devised to eliminate this condition has proved very satisfactory. A channel is first cut into the vertical face of the floor support pitched to the corner of the shaft. Then a gutter of heavy steel is attached in the opening with lag screws, and cemented in place. This gutter, being open, can be readily cleaned. It conveys all moisture to a pipe in the corner of the shaft which discharges into the drain in the pit.

T. All equipment in which lubricating grease or oil is used should be examined carefully to make sure that there is no possibility that the lubricating material may get into the product. Water forced under a linking machine becomes contaminated with the heavy lubricating machine grease that has dropped onto the table from the working parts of the machine. To prevent contamination of sausage by this grease and water combination, the linking machine may be placed in a stainless steel pan at least two inches deep. If the possibility of contamination of products by lubricants exists, the establishment should be required to take suitable corrective measures without delay.

U. The sprays in Jourdan-type cookers may be arranged so that water strikes the roller assembly of sausage cages or smoke trees and washes grease or oil down onto the product and into the water reservoir at the bottom. To correct this condition, the sprays may be lowered, or a splash shield may be placed on both sides of the rail and extended down from the top of the cabinet a sufficient distance to prevent the rollers from being sprayed with water.

V. Metals such as copper, cadmium, lead, and the like are not acceptable for use in the construction of containers, fittings, pins, and similar devices when such metal comes in contact with product.

W. Metal drums coated on the inner surface with lacquer or resin may be used for rendered fats provided the coating is smooth, odorless, hard, and does not peel or blister. The coating should be approved by the Laboratory Branch of the Technical Services Division before its use is permitted. Such approval is usually given only to the manufacturer, and then only after submission of a statement showing the chemical composition, intended use, method of application, action while in contact with water and fat, and any toxicological data deemed necessary.

X. Several types of machines used to overwrap cartons of product, such as sliced bacon, luncheon meat, frankfurters, etc., are designed in a manner requiring product in a carton to be conveyed beneath the heat sealing unit before the wrapper is applied. Inspectors should closely examine such equipment to determine if the construction permits product contamination. If so, the establishment should be required to install a removable rust-resistant metal tray just below the heat sealing unit.

308.13 Contaminants—Bacterial. The pusher bar of some frozen meat choppers feeds frozen blocks of meat to the chopping blade. There is a space of a quarter inch or more between the pusher bar and the bed of the chopper. The pusher bar should be removed at the close of a day's operation and thoroughly cleaned. It should be left unassembled and allowed to air overnight.

A. Sausage grinder plates of the so-called reversible type are constructed with removable bushings and sleeves. This permits the accumulation of a considerable amount of meat, fat, and meat juices on the inner surfaces of the various demountable parts during grinding operations. The parts must be completely demounted for cleaning daily.

B. The feeder screw of most meat grinders is cast, and the center consists of a hollow core. It is very important that close examination be made of such equipment to detect any crack, flaw, or faulty construction that would result in an unsanitary condition.

C. The hollow aluminum emptying plug in some silent cutters has a pan in the bottom and is held in place with small stove bolts seated in the body of the plug. At times, these become loose and disappear. Continued use of the chopper causes the meat juices and particles of meat to get into the plug proper. The pan can be removed leaving the opening which can then be properly cleaned. The packing nut at the top has a gasket and cap to keep grease out of products. To make this packing nut more secure, cap screws should be used and the thread ends drilled permitting them to be held in place by a wire; this eliminates any chance for metal to get into meat products.

D. Covers to clean-out openings of sausage stuffing machines should be removed at frequent intervals and the interior of the stuffers examined to determine the need for cleaning. The frequency with which the covers are removed and the interiors examined and cleaned depends on the kind of product handled. Particular attention should be given to the interior of stuffers. If particles of meat, fat, liquids, and the like are found, the gasket is worn, defective, or improperly adjusted and permits material to bypass the piston. When such a condition is found, the piston should be "pulled" in order that proper adjustment can be made and the gasket replaced if necessary.

The frequency with which pistons should be pulled depends largely on the condition found on the interior of the cylinder as observed through the clean-out openings and from the top when the piston is in the "down" or loading position. The kind and consistency of product for which the stuffer is used will have a bearing on the frequency of pulling the piston for thorough cleaning. Thus, a stuffer used for a more or less stiff and coarse product would not ordinarily need to have the piston pulled as often as a stuffer used for a soft or paste-like product, providing the gasket, piston, and cylinder walls are in good condition. When pistons are pulled, they should be examined for any appreciable degree of deterioration of the gaskets or any detached fragments that might find their way into product; accumulation and possible decomposition of product beneath the gasket or in the space between the piston and the cylinder wall; and any other unsanitary condition that might be present. Attention should also be given to a possible accumulation of product beneath the overhanging edge of the safety ring bolted to the top of the cylinder. Pistons consisting of two (upper and lower) pieces should likewise be given attention at the time they are removed from the cylinder to determine whether any product or material has found its way into their interior.

When compressed air is used to operate a stuffer or other edible processing equipment, an effective filter should be installed in the air intake so that only filtered air enters the compressor. The compressed air storage tank should be equipped with a drain so that accumulated oil and moisture can be drained away frequently. Water and oil traps should be installed in the air

Section 308.13(D)

lines between the compressed air storage tank and the stuffer. It is desirable that the spent air be exhausted outside the building so that fine particles of oil and moisture do not permeate the air in the sausage-stuffing department.

E. The stainless steel strips on the base of some bacon slicing machines do not fit tightly, and some fat and meat juices work their way under the strips and become sour or rancid. These strips can be removed and the area under them cleaned. The strips can then be welded to the base with a stainless steel weld which is ground smooth and polished. Also, the guide rod for the meat holder on some bacon slicing machines has a recessed area at one end in which a certain amount of fat and grease accumulates. The guide rod should be removed as often as necessary to maintain proper sanitation, and the recessed area should be properly cleaned daily.

F. The construction of gate valves used on the lower openings of edible rendering tanks permits passage of a considerable amount of meat tissues, bone fragments, fats, and the like into the valve bonnet. To assure sanitary maintenance of this type of gate valve, the inner parts of the bonnet must be flushed daily. Furthermore, the valves must be completely dismantled as often as necessary for thorough cleaning and inspection.

Several acceptable methods of installing openings into valve bonnets for daily flushing with hot water and/or steam have been devised. Combination steam and hot water lines may be permanently connected to the bonnets; however, if this is done, adequate precautions to prevent back-siphonage into the potable water supply are necessary. Gate valves used for the purpose described above should be provided with similar facilities for daily clean-out and a program of dismantling as often as necessary should be initiated without delay.

G. Expellers used in rendering of edible products must be cleaned thoroughly following use. All parts of this equipment should be accessible for cleaning and inspection. To accomplish this, it has been found necessary to require removal of the plates forming the barrel around the press worm. Also, demounting or providing clean-out and inspection openings in the feeding mechanism has been found necessary.

H. Disease transmitted through meat food products frequently originates from an infected meat handler. A wide range of communicable diseases and infections may be transmitted by food handlers to other employees and consumers through contaminated meat food products and careless handling practices. Boils, infected cuts and sore throats are sources of organisms which cause staphylococcal food intoxication, the most frequently reported type of food-borne disease.

308.14 Part 308.14 of the Meat Inspection Regulations identifies responsibility of operators of official establishments to see that no person who is affected with any disease in a communicable form works in any area of a packing establishment where there is likelihood of disease transmission. The operators of meat packing establishments are required to assume the

responsibility for prompt reporting of all suspect cases of communicable disease among their employees to local health authorities.

308.15 Equipment---Care, Reconditioning.

A. Properly equipped tables, sprays, and the like should be furnished wherever necessary for cleaning product that has accidentally become soiled.

B. Equipment should be provided for receiving trolleys, gambrels, sticks, and smoke sticks for transfer to a suitably equipped place for cleaning before reuse.

C. Since ozone masks odor, thereby interfering with inspection, equipment that produces ozone in appreciable amounts may be used only in coolers set aside solely for the aging of meat. Other operations requiring the continuing presence of inspectors and plant personnel should not be conducted in such coolers. The concentration of ozone in the air should not, at any time, exceed .1 ppm. Ozone generating equipment must be controlled to assure that this level is not exceeded, and measuring devices must be available to record the ozone concentration at any time. Prior to periods when inspections are performed, the ozone generating equipment must be shut off and the ozone in the air permitted to dissipate. All proposals for installation of ozone generating equipment should be referred to the Meat Facilities and Equipment Group, Technical Services Division.

D. Unnecessary pipes, wires, strings, and other material should be removed and no trash should be allowed to accumulate.

E. Cutting boards should be as small as is practical for the purpose. Such boards should be kept smoothly planed and removed daily for cleaning on all surfaces.

F. Carcass shroud cloths should be thoroughly rinsed following washing to assure the removal of all soap or detergent compound.

G. Storage compartments of "snow ice," "flake ice," "pac-ice," and similar equipment should be lined with stainless steel or other rust-resisting metal. The metal should be of sufficient thickness to withstand repeated striking of a shovel without puncturing. Suitable perforated, rust-resisting, and removable metal drainage plates should be provided in the bottom of the ice storage compartment, and frequently inspected to assure their cleanliness. Some of the equipment used for the production of various forms of flaked ice is so constructed that the water resulting from the melted ice is collected in a space below the ice storage compartment. This water may not be used for the production of ice nor should it be permitted in potable water lines or supply. There is no objection to prechilling the water intended for the manufacture of ice by circulating it in closed coils submerged in the cold water beneath the storage compartment.

H. Corrosion of galvanized metal equipment may be prevented by frequent thorough cleaning followed by a light application of colorless, odorless, paraffin oil. Equipment that is to come in contact with product should be

washed before it is used in order to remove excess oil.

I. Wooden secondhand containers that have been reconditioned prior to receipt at an establishment should not be accepted for use since it is impossible to give the inspection necessary to determine fitness for use as contemplated in Section 308.12(a) of the Meat Inspection Regulations. Wooden containers are frequently used in industry for various chemicals and insecticides, some of which are highly poisonous. Containers previously used to hold food may contain vermin excreta and decomposed material consisting largely of food spoilage organisms and dangerous toxins. As the complete removal of dangerous substances cannot be accomplished with certainty from containers made of porous material such as wood, such containers that show evidence of dangerous contamination should be rejected.

J. Secondhand containers made of nonporous material, such as steel drums intended as containers for edible rendered fat, may be reconditioned without prior inspection; however, inspectors should examine such containers very carefully to determine that effective cleaning and preparation for use has been accomplished. The inspection would include.

1. Wiping the inner surface of the container with a clean white cloth or towel to determine whether all former contents have been removed.

2. Looking for a spotted appearance of the inner surface which may be an indication that the new lining will not adhere over improperly cleaned old linings or rusty surfaces.

3. Looking for dents in chime and sides of drum. These areas should be free from damage that would interfere with satisfactory cleaning and inspection. In determining the acceptability of steel drums, inspectors should apply the usual product container requirements for cleanliness and absence of probable sources of contamination. The acceptability of the coating on the inner surface of any metal container can be determined by obtaining from the Management the name of the lining material, name and address of the firm that applied the coating, and forwarding this information to the Laboratory Branch of the Technical Services Division, Washington, D. C.

K. Common steel drums such as lard drums may be used only as containers for meat products other than edible rendered fats under the following conditions:

1. They may be used only as shipping containers. Drums are not to be used as operational containers for edible products in official establishments.

2. They must be acceptably galvanized.

3. The inside and outside of the drums must be free of rust and corrosion.

4. The body must be reasonably free of dents and distortion.

5. Seams must be tight, reasonably free of dents, and free of any kind of debris.

6. Drums must be lined with a water tight bag of approved plastic. The plastic liner must have a thickness gauge of at least 2 mils. Liners of greater thickness should be used when necessary to avoid tearing when loading and unloading.

7. Drums must be thoroughly clean inside and out before insertion of liner.

L. Inspectors should give close attention to the reconditioning of wooden curing vats where such equipment is still used. After being emptied, the vats should be flushed with water and removed from the curing department. All splinters, blisters, badly discolored wood and ridges should be removed from the inner surface of the vat and a smooth clean inner surface should be obtained. The outer surface of the vat should be smooth with the hoops free from corrosion. Badly rusted hoops should be replaced with new galvanized or stainless steel hoops. After the inner and outer surfaces of the vat have been properly smoothed, it should be flushed with clean water and steam to remove particles of wood and dust. A suitable truck should be used for returning the vats to the curing department since rolling the vats on the floor results in contamination of the outer surface and top of the vat.

Paraffined paper cups have been used to close the bung hold of reclaimed or secondhand barrels and tierces to prevent contamination of the interior.

PART 309 - ANTE-MORTEM INSPECTION

309.1 The purpose of ante-mortem inspection is to accept for human food only those animals that yield meat or meat food products that are healthful, safe from harmful chemical and drug residues and are consistent with the consumer's sense of decency. Achieving this purpose results in:

A. Removing from human food channels those animals having conditions undetectable on routine post-mortem inspection (chemical poisonings and diseases affecting the central nervous system).

B. Preventing unnecessary contamination of the slaughtering department by diseased animals.

C. Obtaining information on suspect animals for sound post-mortem carcass disposition.

D. Withholding from slaughter animals exhibiting abnormal conditions that make them unfit for human food.

309.2 Required Facilities and Equipment. An official establishment must furnish and adequately maintain the following facilities and equipment to enable the inspector to perform ante-mortem inspection on all animals presented for slaughter:

A. Covered and properly identified pens for segregating suspect and condemned animals. Covered restraining devices such as chutes, squeeze gates, boxes, or any other effective device for restraining animals requiring close examination.

B. Thermometers.

C. Establishment employees designated by management for sorting, restraining, moving, and identifying animals.

D. Covered pens in sufficient numbers to facilitate ante-mortem inspection in inclement weather.

E. When the official establishment serves both as a slaughtering facility and a public stockyard, separate pens must be designated for animals presented for ante-mortem inspection and those destined for resale. Ante-mortem inspection should only be performed on animals identified for slaughter by the establishment.

F. A walkway 48 inches or more above the pen floor with a 24-inch wide platform and equipped with a safety rail must be provided along the inside of the pen for ante-mortem inspection of horses.

309.3 Procedures for Animal Examination.

A. To detect abnormalities, animals should be examined when still and from each side when in motion. At both times the animals should be as free from excitement as possible.

B. Animals showing symptoms of disease (central nervous symptoms, inability to react normally to stimuli, abnormal temperature, dyspnea, etc.) or other abnormal conditions (injuries, swelling, etc.) are to be separated and placed in designated pens for examination by a veterinarian. The phase of ante-mortem inspection which consists of identifying and segregating animals exhibiting abnormal conditions can be performed by a veterinary meat inspector or a trained meat inspector under the supervision of a veterinarian. Identification of U. S. Suspect swine must include the use of tattoos to maintain the identity of the animals through the dehairing equipment when such equipment is used.

C. The final disposition of an animal exhibiting an abnormal condition on ante-mortem inspection is to be made by a veterinarian. The disposition of the animal should be one of the following:

1. Release the animal for slaughter (examination reveals no evidence of disease or abnormal condition).

2. Identify the animal as a U. S. Suspect. Cattle affected with epithelioma of the eye, actinomycosis, or actinobacillosis to such an extent that the lesions would be readily detected on post-mortem examination during normal inspectional procedures shall not be individually tagged on ante-mortem inspection with the "U. S. Suspect" tag. Such animals must, however, be handled as "U. S. Suspects" and identified during slaughter with the "U. S. Retained" five-section tag. Other U. S. Suspect animals will be individually marked, observed and symptoms recorded on MI 402-2.

3. Mark the animal as U. S. Condemned (where the history and/or symptoms indicate the presence of a disease entity or toxicity resulting from chemical or biological agents for which the Regulations require condemnation).

D. Condemned animals should be handled in one of two ways:

1. Promptly destroyed by establishment personnel and disposed of according to Part 314 of the Regulations.

2. Withheld from slaughter with the condemned animal placed in an acceptable pen and held for observation or treatment. With the agreement of local and/or Federal animal health officials, the animals can be transported to a location other than the official establishment. When an animal is condemned and handled according to procedure 2 and recovers or a required withdrawal time is met, the animal, if returned for slaughter, must be re-examined on ante-mortem inspection by a veterinary meat inspector and a disposition made as outlined in 1, 2 and 3 of Paragraph C.

E. An identification system of animals having received ante-mortem inspection and having been accepted for slaughter should be established. Animals are not to be removed from pens and sent to slaughter unless a report signed by the ante-mortem inspector certifying that inspection was performed is available to the final inspector prior to actual slaughter of the animal. The report should have as a minimum the following information: Date, species, number, description of the animals, hour of inspection, lot or pen number, and signature of the inspector performing ante-mortem inspection.

The pen card is to be delivered to the inspector assigned to the slaughtering operation immediately prior to or at the time the animals are driven into the establishment for slaughter. Continual comparison between the number of animals certified on the report and the number of animals slaughtered should be made throughout the day's kill to positively determine that all animals being slaughtered have received ante-mortem inspection. The ante-mortem inspection pen cards of each day's kill should be held at the establishment for thirty days. Modifications of this procedure to fit small, large, or unusual operations are acceptable provided they assure identification of all animals receiving inspection. Any modified system must be approved by the District Director. Supervisors should continually check the procedure to determine that the goal of ante-mortem identification of animals destined for slaughter is being met.

309.4 Ante-Mortem Inspection of Cattle with Proteolytic Enzymes.

A. Only animals showing no symptoms of disease or other abnormal conditions are to be injected with an enzyme solution prior to slaughter.

B. A minimum of two minutes and a maximum of 30 minutes should lapse between the injection and the time the animal is slaughtered. Animals showing any reactions following the injection are to be held for examination by the veterinarian.

Some reaction symptoms are salivation and incoordination at the time of injection, dyspnea, blood tinged froth at nose and mouth, rapid pulse, edema and/or hyperemia of the throat area.

Veterinary meat inspectors may release the animal for slaughter after it is observed to be normal.

309.5 Diseases and Conditions.

A. "Downers" are animals that are unable to stand or have abnormal changes in locomotion and should be withheld from slaughter for a period of 24 hours. After this period of time, if the animal is progressively weaker and/or the symptoms exhibited by the animals are more exaggerated, they should be marked as U. S. Condemned and handled according to Section 309.16 of the Regulations. These animals that are not condemned should be made a U. S. Suspect and the final disposition based on ante-mortem and post-mortem findings

along with a histopathological examination of tissue specimens of heart, brain, liver, kidney, spleen, and all diseased tissues. An exception to this are those animals exhibiting symptoms which indicate recent trauma or a localized condition that mechanically impairs the animal's movement. Such animals can be sent to slaughter as a U. S. Suspect provided any required withholding periods relative to drugs and chemicals have been met. "Downers" showing symptoms of a disease entity for which condemnation is required by the Regulations are to be marked as U. S. Condemned on ante-mortem. "Downers" condemned on ante-mortem which are held for treatment or observation in lieu of immediate destruction should be isolated and placed in facilities reserved for this purpose.

B. Animals exhibiting symptoms of certain disease conditions in addition to the ones listed in the Regulations should be condemned on ante-mortem inspection. This includes symptoms of central nervous system disorders in which animals are showing either a depressed (drowsiness, weakness, or coma) or an exaggerated activity (licking, staggering, circling, muscular tremors, etc.) These symptoms of central nervous system disfunction could indicate one of the following disease conditions:

1. Sporadic bovine encephalomyelitis.
2. Infectious Thromboembolic Meningo - encephalitis.
3. Salt poisoning.
4. Metal poisoning.
5. Fluorine poisoning.
6. Chlorinated hydrocarbon pesticide poisonings.
7. Organo-phosphorus pesticide poisonings.
8. Plant poisonings.

C. Calves lacking in vigor and muscular coordination as determined by lethargy and inability to stand and walk normally shall not be slaughtered for human food. Calves, regardless of age, that are determined on ante-mortem inspection to be satisfactorily developed and show normal movements and show no symptoms of disease may be passed for slaughter without restriction.

D. Diseases and conditions requiring special handling are as follows:

1. Emergency Slaughter. The provisions in the Meat Inspection Regulations for emergency slaughter are not intended to cover the slaughter of sick or dying animals. Also, animals for which a required drug or chemical withholding period has not been observed are not acceptable under the emergency slaughter provisions.

2. Vesicular Diseases. When a vesicular condition is observed on ante-mortem inspection, the animals should be held under inspection supervision and the matter reported immediately by telephone to the nearest Animal Health Division officials. Federal and state officials in charge of animal disease control will make the final diagnosis and give instructions for the disposition of the affected animals and disinfection of the involved facilities.

3. Investigational Animals. Ante-mortem inspection is not to be performed on experimental or research animals unless authorization for slaughter is received from the Livestock Slaughter Inspection Division.

4. Tuberculin Reactors. Identification of tuberculin reactors includes making a record of the reactor numbers directly from the metal ear tags. When tags are missing from animals otherwise identified as reactors, an accurate description should be made on all reporting forms. This includes the estimated weight, presence or absence of brand marks on the jaw or elsewhere, presence or absence of horns, breed, color, marking and sex. A tuberculin reactor that had died from causes other than slaughter or that is condemned on ante-mortem inspection should be given a thorough post-mortem examination in the inedible products department.

5. Brucellosis Reactors. If a brucellosis reactor is condemned on ante-mortem, the proper information including the disposition of the animal should be forwarded to the Animal Health Division and state livestock sanitary officials. The identity of brucellosis reactors must be maintained to permit proper recording of the slaughter and disposition of the animal.

6. Licensed Biological Establishments. Upon request of the Animal Health Division, an inspector of the Meat Inspection Program may conduct ante-mortem inspection and supervise the final bleeding operations at a licensed biological establishment. The inspector will not supervise intermediate bleeding operations nor salvage exhausted animals. The inspector will check the records, ascertain that the ten days have elapsed after hyperimmunization, and otherwise determine that there is full compliance with Parts 309.7 and 310.16 of the Meat Inspection Regulations. The time incident to servicing these licensed establishments will be charged against the Animal Health Division. No charges will be made for supervision of the final bleeding operations if carried out within a federally inspected establishment.

7. Humane Handling. Inspectors should caution management of official establishments against animal handling practices that result in unnecessary pain or injury to the animals. If after calling attention to unnecessary cruelty or improper handling, prompt action is not taken to correct such practices, the Officer in Charge should report the circumstances to the local humane society office. The inspector should limit his actions designed to correct abuses to encouraging corrective action and reporting incidents of inhumane handling of the animals.

8. Animals exhibiting symptoms of a drug or chemical poisoning should be withheld from slaughter. The District Director should be immediately notified and given as much history as can be obtained on the animals--the clinical symptoms, number of animals, and other pertinent data. This same information should be relayed to the Livestock Slaughter Inspection Division. Animals exhibiting normal behavior on ante-mortem inspection but which have not met a required chemical or drug withholding period must be withheld from slaughter until the required withholding period has elapsed.

9. Control of Escaped Animals. All federally-inspected slaughtering establishments can use tranquilizer darts to control and handle escaped animals. The establishment must agree that it will (1) use a tranquilizer drug approved for use on food animals, and (2) hold animals dosed with an approved tranquilizer drug for the required withdrawal period before slaughter.

Approved tranquilizer drugs (trade names), the food animals on which they may be used, and the required withdrawal periods before slaughter are listed below:

DI QUEL	All food animals	24 hours
SPARINE	All food animals	72 hours
VETAME	Sheep	72 hours
	Cattle	48 hours
	Swine	6 days
TRANVET	Cattle only	72 hours

PART 310 - POST-MORTEM INSPECTION

310.1 Inspectors assigned to post-mortem duties should observe the condition of rooms and equipment and the clothing of establishment employees to see that they are clean and that the equipment, including sterilizers, wash basins, and facilities for inspection, are in proper working order.

310.2 Each inspector performing post-mortem duties should constantly observe the maintenance and use of sterilizers and wash basins during the day and require that they be properly maintained and used.

310.3 Certain areas have been provided and set apart for the exclusive use of inspectors. Establishment employees must not be permitted to encroach on such places to the detriment of inspection work.

310.4 The method of tagging carcasses to indicate various conditions found on initial inspection may be varied, as directed by the Officer in Charge, according to local conditions. One method used with success at several stations is as follows:

- A. Tuberculosis: Tag on left belly.
- B. Slight cervical abscess: Tag low on right foreshank.
- C. Well marked or extensive cervical abscess: Tag in right axillary space.
- D. Cholera, septicemia, etc.: Tag on right belly.
- E. Any condition for which the carcass should not be opened, at least until it reaches the final room: Tag on median line.

For ready identification, the tags printed in black are sometimes used at the head inspection station, and tags printed in red are used at the viscera inspection station.

310.5 The brands "U. S. Condemned" and "U. S. Passed for Cooking" are to be used for marking carcasses and parts. Informal marks and tags should not be substituted for these brands.

310.6 Inspectors are expected and required to make such incisions or inspections as are essential to determine the presence, character, and extent of any condition that might have a bearing on the disposition of the carcass or any of its parts. However, unnecessary mutilation of carcasses or parts that ultimately may be passed for food, and, of course, the unjustified condemnation of carcasses or parts, must be avoided.

310.7 When making inspections of nodes or organs requiring the use of a knife, it is essential that the tissues be sliced in such a way that the

Section 310.7

exposed surfaces may be carefully examined. Hashing nodes by a hacking or chopping method which affords no opportunity to examine the cut surfaces is not acceptable.

310.8 The "final" inspector is the immediate supervisor of the slaughtering and related departments to which he is assigned. He is responsible for all matters pertaining to the inspection. This applies not only to the actual final inspection of retained carcasses but also to the sanitary condition of the premises, the condition and operation of equipment and the work of employees who may be under his supervision. Matters involving structural changes or improvements are generally taken up with the Officer in Charge or his designated assistant.

310.9 Post-mortem inspection of U. S. Suspects should not be performed until the ante-mortem findings have been received by the post-mortem inspector.

310.10 The routine (other than final inspection) post-mortem inspection of every carcass must include a general examination of the entire carcass (outer surfaces and exposed surfaces of cavities) and of the viscera, in accordance with the following:

A. Cattle.

1. The methods employed in handling, stunning, shackling, and bleeding the animals should be observed. (The animals should be handled promptly). The area where the stunned animals are discharged from the knocking box should be kept clean and as dry as possible.

a. When captive bolt stunners of the penetrating type are used over the frontal region, pieces of skin, hair and bone are carried into the brain. When used at the base of the skull, they usually cause extensive hemorrhage in the area. This requires trimming of the neck after the carcass has been split. Proper disposition should be made of hemorrhagic tissue and of the brains that are contaminated with foreign material.

b. When lead or frangible-type bullets are used to stun animals with penetration of the cranial cavity, the brain shall not be saved for edible purposes.

2. When cattle are slaughtered by the "on-the-rail" method, the "rodding" of the esophagus should take place at the time the head is removed from the carcass. Then the esophagus should be effectively closed to prevent the escape of rumen contents. Cattle should be sufficiently far apart to prevent contamination of skinned parts of adjacent carcasses by feet or hide. The heads and corresponding carcasses should be identified by duplicate numbered tags applied by an establishment employee before the heads are removed. The heads should be removed in a manner to avoid soiling them with rumen contents. The skinned heads should not be permitted to come in contact with the floor. The horns should be removed with equipment that is sterilized

after use on each head. All pieces of hide must be removed before the heads are washed. The washing of the heads should be done in compartments or areas which will control the splash of waste water. The nasal and oral cavities should be thoroughly flushed before washing all the outer surfaces of each head.

3. After the head has been placed on proper equipment (standard removable metal head loops or removable hooks that hold the heads by insertion into the foramen magnum) and the tongue suspended from the tissues adjacent to the hyoid bones (on-the-rail layouts), the inspector should carefully observe all surfaces of the head to detect abnormalities and should expose, incise and examine the mandibular, atlantal, (if present) supratharyngeal, and parotid lymph nodes (two each).

4. Following inspection of the lymph nodes on conventional layouts, an establishment employee should detach the base of the tongue from the head so that the tongue hangs only by its anterior attachment at the symphysis of the mandible, thus giving access to the muscles of mastication. In establishments where it is feasible, the tongue may be dropped prior to lymph node incision. The complete head inspection is then performed in a single operation.

5. Prior to inspection the tongue shall be detached sufficiently from the head bones, by an employee of the establishment, to allow a proper inspection to be made of the internal muscles of mastication. These muscles shall be inspected after incising them in such manner as to split the muscles in a plane parallel with the lower jawbone. The masseter muscles also shall be incised, splitting the entire external layer between the outer and intermediate fasciae (If preferred, the inspection of the parotid lymph nodes may be made at this time rather than as indicated above). The inspector should also make a thorough visual and digital examination of the tongue. Ulcers, scar tissue, and the tonsils should be removed by an employee of the establishment under the direction of the inspector. Lesions resembling actinobacillosis or actinomycosis should be carefully examined by the inspector and incisions made, if necessary, to determine the character and extent of the lesions. Tongues affected with cactus thorns and/or cactus thorn abscesses shall be condemned for food under Section 311.10(d) of the Meat Inspection Regulations.

6. Inspection of the head should be completed before viscera inspection of the corresponding carcass is started.

7. After the head has been removed from the carcass and while the head is being cleaned and inspected, establishment employees place the carcass on the skinning bed (except in installations where this procedure is not used). Care must be taken to see that the area is acceptably clean before the carcass is lowered. The head skin must be so manipulated that the tissues of the neck will be protected from soilage and other precautions must be taken to prevent contamination of any of the meat of the carcass. This may be best accomplished by leaving the ears on the hide and head skins tied except in "kosher dressing." The front and hind feet are removed before any other incision is made in the carcass. In removing the front feet, care should be taken to expose as little as possible of the tissues of the foreshank and leave a

Section 310.10(A7)

"tie" of the hide completely covering the shank as far down as possible toward the carpal articulation where the out is made to remove the foot; or the feet may be removed by a single transverse incision through the hide and articulation. Care should be exercised when skinning animals by the on-the-rail type of dressing procedure so that the hide is always reflected away from the carcass starting with the hind shanks and proceeding downward. Lactating udders are removed at this point in such a manner as to prevent soilage of the carcass with udder contents. Any contamination from udder content must be immediately trimmed from the carcass. The supramammary lymph nodes should be left attached to the carcass until inspection is completed.

8. When establishment employees move the carcass from the skinning bed, they must use care to see that the exposed parts of the carcass are protected from contact with the floor or with fixed objects. The floor of this area shall be maintained in a clean and sanitary manner, after each carcass is handled. The dropping of the bung should be made part of the rumping operation. The perineal skin should be reflected laterally over the anus leaving the external sphincter muscle intact. The incision into the pelvic cavity to "ring" the bung should be made with a clean knife. The rectum is then tied in such a manner as to tie off the neck of the bladder. A tie must be made at the point where the small intestine leaves the stomach and at the point where the esophagus attaches to the paunch. At each of these two named points, two ties should be made about 4 inches apart with the contents being stripped from the intervening portion of the intestine or esophagus, respectively, before the second tie is made so that the tissues can be severed with a knife between the ties without any spillage of the contents. The hide over the tail should be pulled directly after "ripping." Procedures at variance with the above may be accepted if the purpose of the requirements is fully accomplished.

9. Over-all observation of the viscera and entire carcass, especially the body cavities, should be accomplished at the time of evisceration. To facilitate the examination, repeated incisions should be made of the right and left bronchial lymph nodes, the medial and posterior mediastinal lymph nodes and the portal lymph nodes. The preparation and inspection of hearts shall conform to one of the following methods.

a. The surface of the heart shall be examined, and a longitudinal incision made extending from base to apex through the wall of the left ventricle and the interventricular septum, after which the cut surfaces and the inner surfaces of the ventricles shall be examined.

b. After the external surface of the heart has been inspected, the organ shall be prepared for further inspection by an establishment employee severing its attachments and cutting through the interventricular septum and such other tissues as will permit him to evert the organ completely. The inspector shall then examine the interior surfaces and make not more than four deep lengthwise incisions into the muscles of the septum and left

ventricular wall, unless the presence of cysts is suspected, when more incisions shall be made. Under this method, care shall be taken not to cut completely through the walls of hearts to be passed without restriction. If necessary to maintain the identity of hearts, the establishment shall provide consecutively numbered tags and appropriately mark the carcasses and hearts.

c. Examination of the liver should include opening the large bile duct. This should be done very carefully as cutting through the duct into the liver tissue will interfere with the detection of the small lancet liver fluke. The incision should extend at least an inch through the bile duct dorsally and in the other direction as far as possible. The beef liver should be palpated on the entire parietal surface and within the area of the renal impression. Palpation should be accomplished by exerting sufficient pressure with the hand and fingers to be able to detect deep abscesses or cysts within the liver. The inspector is expected to palpate the parietal or curved surface and to observe the visceral and parietal surfaces of the lung. The mesenteric lymph nodes and the paunch should be observed or incised if necessary. The inspector must look at the exposed surface of the beef spleen. The junction of the rumen (paunch) with the reticulum (honeycomb) should be carefully palpated to determine whether there are abscesses at this point.

10. Inspection of dressed carcasses must include observation of all surfaces of the carcass. The superficial inguinal (supramammary), internal iliac, lumbar and renal lymph nodes, the region of the kidney and the pillars and flat portion of the diaphragm are to be palpated and observed. Incisions are to be made if necessary.

11. When lesions of actinomycosis are found in the head but not in the viscera, the incision of the body lymph nodes may be omitted. However, a careful survey of the carcass should be made, including palpation of the region of the body lymph nodes for the detection of possible abnormal conditions. The lateral, anterior and medial cervical lymph nodes shall be examined when lesions of actinomycosis are found in the viscera.

12. The post-mortem examination of cattle that have reacted to the tuberculin test should receive special attention in order to locate all lesions. Use the guide entitled, "Inspection of Tuberculin Reactors," in conducting this phase of post-mortem examination. In addition to the U. S. Retained tag number, the identification of the animal should be indicated by the reactor tag number.

13. The fact that an animal has reacted to the test for brucellosis does not require special post-mortem technique. It need not be retained nor classed as a suspect unless cause other than the reaction to the brucellosis test requires such action.

14. Washing of carcasses should be deferred until bruises have been removed and inspection has been accomplished.

15. When evidence of cysticercosis is found in cattle, the final inspection of retained carcasses shall be as follows:

The external and internal muscles of mastication, the heart, and muscular portion of the diaphragm including its pillars, should be carefully and thoroughly sliced to insure the finding of all cysts. Prior to the inspection of the diaphragm its peritoneum shall be removed. The tongue shall be carefully inspected by palpation, and if the presence of cysts in the muscles of this organ is suspected, the tongue shall be thoroughly sliced and all parts closely examined for cysts. In addition to the foregoing, the muscles of the oesophagus, the exposed muscles, and cut muscular surfaces of the split carcass shall be examined. Incisions may be made to expose additional surfaces for examination, but unnecessary mutilation of carcasses which may be passed shall be avoided.

B. Hogs.

1. Inspectors assigned to head inspection are required to inspect hog carcasses to determine whether they have been properly cleaned. The establishment must properly clean hog carcasses before any opening is made for evisceration or dropping the head. Inspectors can assist the management of establishments in assuming this responsibility by pointing out many of the factors that influence satisfactory scalding, dehairing, and cleaning. Some of these factors are water circulation and temperature, number of carcasses, and time carcasses remain in the scalding tub; condition and operation of the dehairing machine, including the water temperature and number of carcasses through the machine. These factors may vary considerably in different installations and with the type of hogs slaughtered; however, when given adequate attention, there should be no difficulty in obtaining satisfactorily cleaned carcasses. The knife or other tool used to partly sever the head should be sterilized after each head is dropped. The carcass should be presented to the head inspector in such a way as to make the cervical lymph nodes readily available for inspection.

2. Both mandibular lymph nodes must be carefully sliced and the cut surfaces examined. Other lymph nodes should be incised for examination when necessary. Exposed muscle tissue should be observed for evidence of cysticercosis or for other abnormalities that might warrant retention of the carcass.

3. When necessary to prevent contamination of the carcass or viscera, the rectum must be tied before evisceration. Establishment employees should exercise care to prevent cutting of intestines and stomach. Carcasses contaminated by stomach or intestinal contents or bile must be thoroughly cleaned before being presented for inspection. Organs must also be cleaned before inspection. Those organs excessively contaminated shall be condemned.

4. Viscera inspection must include observation of the spleen, stomach, and intestines, all sides of the liver and heart, and the parietal and diaphragmatic surfaces of the lungs. The spleen, heart, parietal surface of the liver and lung, and the bronchial, mediastinal, portal and mesenteric lymph nodes are to be palpated. Incisions are to be made if necessary.

5. The viscera inspector should observe the carcasses and insofar as possible, the methods establishment employees use in handling carcasses and parts. Where kidneys are removed with the viscera they must be observed and palpated during viscera inspection, otherwise this examination must be completed during rail inspection.

6. The rail inspector must observe carefully all parts of the carcass. He should require that remnants of liver and lungs, bruises, wounds and other abnormalities be removed by an establishment employee. Care should be taken to detect parasitic infestations, particularly kidney worms (*Stephanurus dentatus*). The cut surfaces of hams, briskets and diaphragms should be observed for evidence of cysticercosis. Establishment employees are required to remove the remnants of spermatic cords, abscesses and bruises that may be present in ham facings.

7. An establishment employee should be required to remove all lymph node tissue from the necks of carcasses retained on account of cervical abscesses or tuberculosis. If slight abscessed heads are passed for food, a careful removal of the mandibular and adjacent nodes should also be required.

8. Inspectors performing the final inspection of hogs retained on account of tuberculosis must examine by incision all important body lymph nodes of such carcasses except as provided below:

- a. Incision of the body lymph nodes may be omitted provided careful inspection of the head and viscera show no lesion other than those in the lymph nodes of the head and mesenteries.
- b. Incision of the prescapular node may be omitted provided careful inspection shows the prepectoral node and the thoracic pleura to be free of lesions.
- c. Incision of the prefemoral node may be omitted provided an examination of the superficial inguinal, sublumbar and iliac nodes shows them to be free of lesions.

9. Establishment employees are required to sterilize implements after their use on retained carcasses.

10. The necks of hog carcasses may be washed after removal of the leaf and scrap fat. The skimmings from the tank receiving the water from neck washing should not be used for edible purposes.

C. Calves

1. Calf carcasses should be cleaned and dressed while they are suspended from an overhead rail.

2. The heads should be thoroughly washed and the cavities flushed in the same manner as cattle heads. Incisions for node inspections may be confined to the suprathyroid lymph node unless there is reason to believe that incisions should be made of the other nodes of the heads.

3. The viscera including the paunch and intestines must be presented for inspection. Viscera inspection should include palpation of the heart, lungs, parietal surface of liver and attached lymph nodes, kidneys, and iliac nodes, with any necessary incisions and a careful observation of remaining parts of the viscera. The inspector must run his hands down the back of each hide on calf on both sides of the midline to detect grubs or dirt; raise the front legs and examine the hide in this region as often as necessary to assure proper cleaning.

4. The skins of bruised calves and those affected with grubs, lice and other skin conditions as well as those found unclean, must be removed as part of the dressing operations at the time of slaughter.

5. The adequacy of dressing and cooler facilities to accomplish sanitary handling of the carcass' viscera and parts, rather than the age of the animal as determined by its teeth or weight, should be considered when an establishment proposes to dress so-called large calves.

6. The establishment has the responsibility of skinning and handling calf carcasses in a sanitary manner. Failure of an establishment to assume this responsibility should be documented by the inspector. If an establishment continues to prepare calf carcasses in an insanitary manner, they should be required to furnish mechanical means of positively separating unskinned carcasses during the dressing and skinning operations. In cases where the establishment handles "hide on" calf carcasses or cold skins calf carcasses, the operation should be prohibited if they continue to conduct the procedures in an insanitary manner.

7. Calf carcasses skinned after chilling must be examined closely to detect injection lesions, foreign bodies, parasites, bruises, or other pathology. All abnormal tissues detected must be removed. If an injection lesion is detected, the carcass must be retained and samples submitted to the laboratory. To the extent practical, the same procedure will be followed as if the injection site were detected on post-mortem inspection.

D. Sheep

1. In order to prevent contamination of sheep heads, scalping operations should be delayed until the pelt has been loosened from the rest of the carcass. Horns should be removed at the time of scalping. Nasal and oral cavities should be flushed before heads are placed on workup tables or in chutes. Overall washing of sheep carcasses should be accomplished before any openings are made for inspection or evisceration.

2. Viscera inspection. The abdominal and thoracic viscera should be observed carefully, and the lungs and liver with related lymph nodes and the heart should be examined by palpation. The main bile duct should be opened and examined for parasites. Incision of the bile duct should be made by the eviscerator as part of the dressing operations.

3. Rail inspection. All parts of the carcass should be observed carefully and an examination made by palpation of the area above the popliteal lymph node, and the prefemoral, superficial inguinal (or supramammary), and prescapular lymph nodes. In palpating these nodes, with the exception of the popliteal, place each node in turn between the thumb and fingers, including as little as possible of the overlying fat and tissue. The inner surfaces of the pelvic, abdominal, and thoracic cavities should be observed.

4. Although the exposure and incision of the body nodes is neither necessary nor desirable as a general practice, such procedures should be followed when efficient palpation fails to establish beyond a reasonable doubt that the nodes are free from lesions of caseous lymphadenitis.

When incision of body nodes is necessary, care should be exercised to leave the nodes in situ and held by natural attachments.

5. The final inspector will, of course, make a thorough examination of retained carcasses and viscera. When caseous lymphadenitis is found, the final examination should include incision of the prefemoral, superficial inguinal (or supramammary), internal iliac, sublumbar, renal, prepectoral, prescapular and popliteal lymph nodes, and of the kidneys and other nodes if the conditions so indicate.

6. A common condition found seasonally in sheep is sometimes referred to as "wild oats" or "needle grass." When only a few carcasses are affected or the carcasses have only a few lesions of the condition, the foreign material should be removed as a part of the dressing operations in order to avoid extra inspection supervision. When larger lots of affected carcasses or ones extensively affected with the condition are encountered, the carcasses may be placed in the cooler for chilling prior to removal of the foreign material. Such carcasses must be segregated and held under circumstances that preclude any possibility of their being released before the foreign material has been removed.

E. Horses.

1. Loose hair can be controlled by spraying the bellies, legs, and feet with water prior to slaughter. Adequate measures should be taken to prevent contamination of carcasses and viscera with urine. Hide removal should be accomplished without the carcass contacting the floor or other fixed objects. The evisceration and splitting operation should be performed in such a manner that the carcass does not contact the floor.

2. Cervical inspection. The head, identified with the carcass by duplicate numbered tags, should be removed immediately after skinning. All hide and external ear canals should be excised prior to thorough washing and flushing of the nasal and oral cavities. Following this, the head should be placed on the inspection rack. The inspection should include a general visual examination of the head for cleanliness, palpation of the submaxillary and pharyngeal lymph nodes and guttural pouch with incision of the parts when

necessary to determine the nature and extent of any abnormality. The nasal septum and turbinate bones should be exposed and given careful examination. This can be accomplished by using one of the following methods or another method found to be satisfactory:

- a. Split the head lengthwise and cut the septum from its attachments.
- b. Cut through the nasal bones transversely with a cleaver at a point in line with the anterior end of the facial crest and pull the nasal bones downward.

The purpose of this inspection is primarily to detect glanders but polypi, rhinitis and sinusitis are also revealed. Horse tongues should be examined for tooth lacerations which must be excised. The dark stain frequently seen on the dorsal surface of horse tongues should be removed by excision. The muscles of mastication need not be incised for examination.

3. Viscera inspection. Palpate the bronchial and mediastinal lymph nodes and lungs and incise when abnormal conditions are found. The heart should be incised as for cattle and examined for endocarditis and melanosis. Palpate the portal lymph node, liver and spleen. Examine the liver carefully on both surfaces. Open the bile duct as for cattle in an examination for flukes. The rest of the viscera and body cavities should be carefully observed for any abnormality. When horse lungs are prepared as edible product, the usual inspection for foreign material in the bronchi should be given.

4. Rail inspection. Palpate the body lymph nodes and observe the carcass for abnormality. Encysted parasites may be found under the peritoneum on the inner abdominal walls. The spinous processes of the thoracic vertebrae in the withers region should be removed and this area as well as the poll carefully examined for fistula. Removal of the first two cervical vertebrae facilitates inspection of the poll area. Equipment used in splitting or cutting the withers and poll regions should be sterilized after each use. The examination for melanosis should be conducted carefully, giving particular attention to the axillary and subscapular space in white or gray horses or when melanosis is found elsewhere. Obviously, this requires that such areas be exposed to view by removing the overlying tissues (dropping the shoulder). The fat and tissues lining the pelvic cavity should be given careful attention, especially along the femoral artery in white and gray horses.

F. Viscera Separation.

Since the opportunities for contamination are great, and product is handled at temperatures conducive to bacterial growth, it is important that inspectors of viscera separation operations be especially alert to any condition adversely affecting the prompt, clean handling of warm offal products. The inspector should be thoroughly familiar with both product and handling procedures. It is of paramount importance to discourage excessive accumulation of any unworked product.

As a guide, various organs and products are listed below by species, along with conditions that require the attention of the inspector:

Beef Products	Condition
Cheeks -----	Contamination, Parasites, Cysts, Eosinophilic Myositis
Lips -----	Hair at angle of mouth, Sores, Tooth cuts, Infections, Contamination
Tongues -----	Foreign bodies, Hair, Tonsils, Pieces of hide, Contamination Hair Sores, Ulcers, Abscesses, Actinomycosis
Poll meat -----	Clumps of loose hair, Contamination, Bruises
Tails -----	Sections of hide, Contamination, Rectal mucosa, Hair
Livers -----	Abscesses, Carotenosis, Flukes, Cirrhosis, Echinococcus, Sawdust, Telangiectasis, Miscellaneous parasitic conditions
Lungs -----	All principal bronchi approximating lead pencil size and larger to be split and examined for ingesta, Abscesses, Contamination, Parasites, Melanosis, Miscellaneous infections
Paunches -----	To be emptied without contaminating the outer surface, All surfaces to be thoroughly cleaned, Parasites, Abscesses
Brains -----	Blood clots and bone splinters
Hearts -----	Cyst, Blood clots, Eosinophilic Myositis
Weasands -----	Cyst, Eosinophilic Myositis, Contamination
Pork Products	
Ham Facings -----	Scar tissue with infection, Abscesses, Bruises, Hair, Scurf, Contamination, Spermatic cords
Hearts -----	To be opened completely and all blood clots removed
Kidneys -----	Cystic kidneys, Kidney Worms, Other abnormalities
Stomachs -----	Contamination, Removal of stomach worms, All stomachs to be treated as edible product. If unsplit, inner and outer surfaces of casings must be presented for inspection
Chitterlings -----	Free from fecal matter and contamination - both sides, Nodules, Excess fat to be removed, Ileocecal valve to be removed. If unsplit, inner and outer surfaces must be presented for inspection
Ruffle Fat -----	Thorn head worm, Small pieces of intestine, Intestinal contents, Lesions
Cheeks -----	Loose hair, Teeth marks, Broken teeth, Sections of ear tubes, Pieces of tonsil, Rosin
Brains -----	Bone splinters, Contamination
Feet -----	Interdigital tissue, Hair Toes, and Claws, Rosin Machine cuts
Spleens -----	Contamination, Parasitic conditions, Abnormalities
Crown (Bung)	
Fat -----	Hair, Sections of genital organs, Contamination
Livers -----	Parasitic lesions, Abscesses, Contamination
Weasand Meat -----	Contamination, Parasites, Must be split and washed
Ears, Snouts, Lips and Head Fats ---	Hair, Bruises, Scurf, Rosin, Rings, Ring holes

Heads Passed for

Cooking ----- Removal of all nodes, All product under control at all times

Tongues ----- Parts of tonsils, Contamination, Parasites

Note: Due to the difficulties encountered in the inspection of hog tongues, the following procedures are described in detail:

1. Many hog tongues are lacerated and soiled during and following the dressing operations. The mutilation is caused in large measure by the action of the beaters of the dehairing machine. When this condition exists; all lacerations and punctures in the tongues must be removed by excision. Stained mucous membranes must be removed by scalding. The trimming of tongues and removal of mucous membranes, when required, should be regarded as a part of the dressing operation.

Threadworms are found in tongues of hogs coming from most sections of the country. All hog tongues used as an ingredient in meat food products or shipped from the establishment labeled as "Pork Tongues" shall be scalded and the mucosa removed. This is the only practical method to assure freedom of this parasite in pork products.

Unscalded swine tongues may be shipped from an official establishment providing they are labeled "Unscalded Pork Tongues," but at no time will they be allowed to be used as an edible product in federally inspected establishments until they have been properly scalded and the mucosa removed.

2. The following two methods of inspecting pork tongues for abscesses have been developed:

METHOD NO. 1 - This method is applicable to hog tongues from sows, stags, and boars. An establishment employee should incise through the midline in the ventral surface of the base or fleshy part of the tongue. This incision need not extend through the dorsal surface. After the incision has been made, the entire tongue should be given a very careful and thorough palpation by establishment employees. A tongue found to contain an abscess may be trimmed to remove the abscess if it is encapsulated. The remainder of the tongue may be passed for food if not contaminated in the trimming process.

Inspectors assigned to supervise this part of the viscera separating operation should reinspect a sufficient number of tongues to ascertain that all abscesses are being eliminated. This reinspection should be made while the tongues are warm and should consist of a very careful palpation of each tongue examined.

METHOD NO. 2 - This method is not applicable to tongues from sows, stags, or boars. An establishment employee should carefully palpate each tongue promptly after removal from the hog's head. The disposition of tongues found to contain abscesses should be as described under Method No. 1. The meat inspectors supervising this operation should select approximately 10 percent of the tongues that have been passed by establishment employees and reinspect them by

thorough and careful palpation while the tongues are warm. If any abscesses are found on reinspection, all tongues prepared previously during the day by this method should be given sufficient reinspection including incising as in Method No. 1 if considered necessary to assure that no abscessed tongues are passed for food.

Since the effectiveness of palpation depends on the tissues being pliable, the importance of performing examination by establishment employees and reinspection by meat inspectors before the tongues become chilled and firm must be considered in establishing inspection routines.

Sheep Products

Condition

Tongues -----	Removal of tonsils, Lacerations, Abscesses, Hair sores, Contamination, Stained tongues to be scalded to remove mucous membranes
Cheeks -----	Ear tubes, Contamination, Pieces of wool
Livers -----	Parasites, Cystic conditions, Scar tissue, Abscesses, Flukes
Caul Fat -----	Bladder worms, Nodules, Abscesses, Contamination
Paunches -----	To be emptied without contaminating the outer surface, All surfaces to be thoroughly cleaned, Abscesses, Parasites
Ruffle Fat -----	Pieces of small intestines, Contamination, Abscesses, Parasites
Lungs -----	Nodular parasites, Abscesses, Melanosis, Abdominal tissue, All principal bronchi to be split (pencil size and larger), Inspection for contamination of bronchi by ingesta

Calf Products

Tongues -----	Removal of tonsils, Hair sores, Abscesses, Foreign bodies
Cheeks -----	Ear tubes, Sections of hide, Contamination
Lips -----	Sores, Hide at angle of mouth, Tooth cuts, Contamination
Paunches -----	(To be handled and inspected similar to cattle paunches
Feet -----	Removal of Hoofs, Hide, Hair, Contamination, Identified with carcass until after post-mortem inspection is complete.
Rennets -----	When abomasi of calves are used to produce rennet, they do not need to be thoroughly cleaned; They may be emptied of their contents in an edible products department provided the operation creates no nuisance. The containers should be marked "calf rennets" and "inedible."
Brains -----	Blood clots, Bone Splinters

Pharmaceutical products should be prepared, collected, and stored in such manner that there will be no interference in the preparation of edible products or the inspection of such products.

310.11 A clean aqueous solution of common salt not exceeding 20 percent salometer strength may be used at official establishments for wetting cloths prior to their application to dressed carcasses of any species, under the following conditions:

Section 310.11(A)

A. The cloths must not exceed in weight or thickness that of the heavy grade of muslin commonly used for clothing cattle carcasses. Aside from unavoidable overlapping at certain points, the cloths should be applied in only a single layer.

B. Rolls of cloth such as may be applied in the furrow of the neck and in the renal and iliac regions of cattle carcasses should not be wet in salt solution.

C. Salt solution may be applied to carcasses only once and only in the manner hereinbefore specified unless the carcasses are to be salt cured in their entirety in the establishment where slaughtered, in which case measures should be adopted that will maintain the identity of carcasses so treated without material additional supervision. If carcasses enveloped in cloths are placed in bags or other coverings for shipment, such outer coverings should bear prominent, legible marks of inspection.

1. Acetic acid solution may be used at official establishments for wetting shroud cloths prior to application to dressed sheep carcasses provided the acetic acid solution does not exceed one percent.

2. Sodium hypochlorite solution not exceeding 20 parts per million may be used on shroud cloths prior to their application to dressed carcasses of any species under conditions outlined in A, B, and C of this section.

3. Carcasses should be branded in the manner prescribed by the Division, and methods should be adopted that will avoid impairment of the legibility of brands by the application of the wet cloths. When carcasses are forwarded from official establishment without removal of the cloths, additional brands, if necessary, should be applied to the carcasses at locations that will be clearly visible at all times without removal of the cloths.

4. Carcasses should not be clothed in a manner that increases their weight through absorption of water.

310.12 The use of fountain-type brushes for washing carcasses and parts is not acceptable.

310.13 Cattle. Physiological effects have been observed on post-mortem inspection in carcasses and organs injected with enzyme solutions. Some of these effects are as follows:

A. Hyperemia of the subcutaneous fascia.

B. Edema and/or hyperemia of the lymph nodes (particularly those which serve peripheral areas).

C. Red-stained serous fluid in the pleural cavity.

D. Congestion of thoracic and visceral organs.

E. Edema and hemorrhage of lungs and kidneys.

Veterinarians observing slight physiological effects in the carcass may pass the carcass for food without further restriction after removal of the affected tissue. A carcass which reveals effects more severe than slight congestion of subcutaneous tissues in the carcass or viscera should be condemned for food.

310.14 In cases where sheep pancreatic glands are to be used for edible purposes, the inspectors should adjust their inspection procedures to assure that no tapeworm infested glands are used. Tapeworms in bile duct indicate possible presence of infested glands. This does not apply to pancreatic glands used for pharmaceutical purposes.

310.15 Swine. Heads sold intact (market heads) must be thoroughly cleansed by the injection of live steam through the nasal passages.

310.16 Procedures to be followed when anthrax is encountered in swine on the slaughtering floor:

A. Preliminary clean-up and disinfection:

1. Immediate cessation of operations including sticking.
2. Remove immediately the affected carcass.
3. Inspect and condemn all dropped heads from the point of detection to the head dropper.
4. Thoroughly cleanse and disinfect all knives, aprons, boots, and other equipment used by the employees contaminated through contact with anthrax-infected material.
5. In lieu of draining the scalding vat, the water may be heated to the boiling point.
6. Cleanse floors, benches, and other equipment contaminated by the affected carcasses with water heated to 180° F.
7. Cleanse and disinfect arms and hands of employees who have contacted infected materials as outlined in Part 310.9(e)(3) of the Regulations.
8. Trim all stick wounds from the point of detection to stickers.

B. General clean-up and disinfection: Procedures outlined in the Regulations shall be followed upon completion of the slaughtering of the lot of hogs of which the anthrax-infected animals were a part.

310.17 Kidneys shall be exposed from their fat covering and kidney capsule by an establishment employee. This may be done prior to viscera inspection and the kidneys examined with the other visceral organs or the kidneys may be exposed prior to rail inspection and the examination made as part of the rail inspection. Kidneys will not be required to be removed from the carcass when inspection is performed at the rail station.

Kidneys with a slight cystic condition should be passed for food after the cysts are removed by a house employee. This arrangement can be handled similar to that for "spotting" parasitic pork livers. Inspectors shall routinely survey this procedure to assure compliance. Kidneys with cystic lesions more than slight in nature shall be condemned.

Kidneys with white spots or streaks caused by lymphocytic infiltration shall be condemned if the lesions are more severe than slight. All kidneys showing pathological lesions such as abscesses, or nephritis shall be condemned.

PART 311 - DISPOSAL OF DISEASED
CARCASSES AND PARTS

311.1 Uncomplicated arthritis as seen on post-mortem is commonly a residual lesion of a previous systemic disease such as erysipelas, brucellosis, etc., from which the animal has recovered. When the lesions of arthritis are so distributed in the carcass that removal is impractical, the carcass shall be condemned. All affected joints and regional lymph nodes should be removed on the dressing floor. Calf carcasses affected with arthritis shall be completely skinned prior to removal of affected tissue.

311.2 A general guide in respect to the terms "slight," "well marked," and "extensive" as they apply to tuberculosis nodes is as follows:

A. Slight - The lymph node is not enlarged and there is more healthy than diseased tissue.

B. Well Marked - There is more diseased than healthy tissue with or without some lymph node enlargement.

C. Extensive - Lymph nodes are greatly enlarged or nearly all the tissue is involved.

311.3 Heads tagged for slight abscesses shall be condemned when the mesenteric nodes are found to be tuberculous. The condemned head will be reported as being condemned for tuberculosis.

311.4 A small well-encapsulated abscess in a lymph node of a hog head will not necessitate condemnation of the entire head. It may be reported as a cervical abscess and the head passed for food after complete removal and condemnation of the diseased lymph node. If only the head is affected, the lesion should be reported in the unlisted tags and the carcass appropriately identified on the post-mortem report.

311.5 Cattle which have reacted to the tuberculin test and in which no tuberculous lesion is found on post-mortem examination should be described by the phrase: "No gross lesion found."

311.6

A. Specimens of lesions of tuberculosis or those resembling that disease found by veterinarians in the post-mortem examination of a tuberculin reactor or of nonreactor bovine animal should be mailed to the National Animal Disease Laboratory, Diagnostic Services, T.B., Ames, Iowa. In those cases where the Animal Health Division inspector has determined a lesser number of laboratory specimens are sufficient in heavily infected herds, he will so inform the veterinary meat inspector. Specimens of skin lesions should not be forwarded for examination.

B. When considering nonreactor tuberculosis lesions, and a laboratory diagnosis is necessary to determine the disposition of a carcass or part,

Section 311.6(B)

duplicate specimens of the lesions should be forwarded to the Pathology Laboratory. In such cases, Form MI-403-8 should indicate the carcass or part is being held pending laboratory diagnosis.

C. Specimens should be fixed in a preservative as soon after death as possible. This is necessary to prevent a reduction in the number of tuberculin organisms present in the tissue. If there is a sufficient amount of lesion tissue, one portion should be placed in formalin solution and the other portion in chloramine T. If there is only enough lesion tissue for one sample, it should be forwarded in a chloramine T solution.

D. ANH Form 6-35, Report of Nonreactors Showing Tuberculous Lesions or Thoracic Granulomas, will be used to identify nonreacting animals showing lesions suspected of being tuberculous and granulomas in the thoracic cavity. A copy of this form will now be used to accompany specimens from nonreactors which are submitted to the National Animal Disease Laboratory (NADL), Ames, Iowa.

Form MI-403-8, Pathological Laboratory Request Report, will be used to identify specimens sent to Meat Inspection Laboratories, and specimens from reactors sent to NADL. This form will no longer be used to accompany specimens from nonreactors sent to NADL.

Form MI-403-6, Final Post-Mortem Disposition of Retained Carcasses and Parts, will be used to record post-mortem findings on all retained carcasses and parts, and report tuberculosis and brucellosis reactors to the veterinarian in charge of the Animal Health Division and the state livestock sanitary official in the state in which the reactor originated. On the copy of the form submitted to the ANH veterinarian, the lesion specimens from tuberculosis reactor animals sent to NADL will be identified beneath the appropriate tissue by an "F" if the specimen is shipped in formalin, a "C" if the specimen is forwarded in chloramine T, or an "F" and a "C" if part of the lesion is shipped in formalin and part in chloramine T.

E. Additional time required for preparing specimens for mailing, as well as the time expended to assemble and report information available at the slaughtering plant, should be billed against the Animal Health Division on C&MS-488. This service should be identified as "lesion specimen" on Form C&MS-488. Charges should not include time required to perform post-mortem examination of reactors or nonreactor animals.

311.7 Brucellosis reactors should be reported on a separate Form MI-403-6. This form should not be used for reporting any animal not classed as a reactor to the brucellosis test. On the report the reactor should be identified by the number of the official reactor tag affixed in the field, or if it is not present, other identifying ear tag numbers should be listed. Where no tags

remain, record any identifying features or characteristics of the animal. If a "retained" tag is also used, the number should follow below the reactor or other ear tag number. Each reactor should be recorded separately on the report under the heading "Brucellosis Reactor." This term is regarded as sufficiently informative for all reporting purposes unless the carcass is retained. In the latter case, the term "Brucellosis Reactor" should be followed by the diagnosis or cause for retention and a description of the lesions or conditions placed opposite the "retained" tag number.

The names of owners should not be given on Form MI-403-6. A carbon copy of the report should be sent to the veterinarian in charge of the Animal Health Division in the state in which the reactor originated. A copy of the 403-6 report may be sent to the state livestock sanitary official.

Brucellosis reactors marked as suspects and those retained on post-mortem inspection for causes other than being a reactor should be recorded also on Form MI-403, Ante-Mortem and Post-Mortem Inspection Summary, in the regular way for the disease or condition causing the retention, but without a notation that the carcass was that of a brucellosis reactor. Otherwise, no entries regarding brucellosis reactors are necessary in making up Form MI-403.

Inspectors performing ante-mortem and post-mortem inspection should give particular attention to assure that all brucellosis and tuberculosis reactors slaughtered are identified and reported. Form ANH-1-68, Report of Brucellosis and Tuberculosis Reactors Slaughtered That are Not Properly Identified When Received, should be completed under the following conditions:

A. Whenever the "B" or "T" brand is missing or not legible on the left jaw, or whenever the reactor tag is not in place on the left ear or forms which should accompany the animal are incorrectly executed or missing, the report of such improper identification should be furnished to the state and Federal livestock disease regulatory officials in the state from which the animal originated.

B. Whenever reactors are slaughtered without prior notification to inspectors, a report should be made to the Animal Health veterinarian in charge of the state in which the cattle were purchased. The slaughter of reactors should not be delayed because of lack of identification or shipping permits. After such cattle are slaughtered, all details concerning lack of identification should be forwarded in the report as outlined.

311.8 Testicles from bulls that have reacted to the brucellosis test must not be passed for food purposes.

311.9 Animals known to have recovered from listerellosis may be slaughtered as suspects. If found free from disease conditions which would require other disposition, the carcass and viscera may be passed for food but the head should be condemned.

Section 311.10

311.10 Hogs affected with atrophic rhinitis may be identified by a characteristic disfiguration of the nose and complete or almost complete absence of the nasal turbinate bones. Small amounts of pus or catarrhal exudate may be found in the nasal sinuses. The soft tissues of the turbinates may be present but folded against the nasal cavity wall, since the supporting bony structures have disappeared. Abscesses or caseous necrotic lung lesions that are well circumscribed have been found in old cases and are probably due to inhalation of tissue particles or exudate from the nose during the active stage of the disease. This condition is usually localized and the tissues of the head that are used for food can be removed without contamination.

311.11 Exogenous pigments such as the lipochrome or carotenoid are formed outside of the body. These are the fat soluble pigments of green plants which give the normal yellow color to animal fat. They also cause hepatic carotenosis, an unusually yellow liver, which should be condemned under Section 311.32 of the Regulations.

Occasionally all or several bones of young animals slaughtered in apparent normal health show a reddish brown or chocolate brown color. The pigment here is a porphyrin. Animals showing this condition should be boned.

The misuse of injectable iron preparations in the muscles of the hindquarters of swine is evidenced by brown and yellow deposits in areas about two inches in diameter. These areas often extend the length of the semitendinosus muscle on the posterior aspect of the femur. This condition is the result of intramuscular injections in adult swine of an iron preparation. Since this injection is known to injure the muscle sarcoplasm, those portions affected should be removed and condemned. The remaining muscle tissue may be passed for food. The detection of this condition is made most often during ham slicing operations.

311.12 Endogenous pigments are formed inside the body. Those formed within individual cells are known as autogenous pigments; those formed by the liver are called hepatogenous, and in the blood, hematogenous.

The most important autogenous pigment is melanin. Melanin is the pigment which gives color to the skin and hair. Deposits of melanin are normally found in the surface tissue of the tongue, brain, lips, and palate of certain animals.

A condition known as melanosis occurs occasionally which is a deposition of melanin in various organs, especially the lungs and aorta, as black spots of irregular shape. This is not sufficient cause to condemn the animal as there is no change in the texture, consistency or form of the tissue. The affected parts can be radically removed and the carcass passed for food.

If deposits of melanin located in the muscles, connective tissue, peritoneum, and fat are not associated with characteristic malignant tumor formation, the carcass may be passed for food after removal and condemnation of the affected portions.

If the character and location of the melanin deposits are such that complete extirpation is difficult and uncertainly accomplished or if the deposits render the organ or parts unfit for food, the affected organs or parts must be condemned. When melanin deposits are distributed in the carcass or part in such manner that removal is impractical, the carcass or part must be condemned.

The slight melanin deposits occasionally found in the spinal meninges are not considered significant unless they are also present in the sheaths of the spinal nerves and extend into the meat. If such is the case, it may be necessary to bone the affected part or parts to remove deposits of melanin.

In hogs, uniform melanin deposits over the skin or in circumscribed areas in the skin need not be removed unless the character is such that melanin deposits are tumorous or smeary.

When melanin deposits are associated with characteristic malignant tumor formation, disposition shall be made in accordance with the Meat Inspection Regulations.

Another autogenous pigmentary condition is known as brown atrophy. It is often seen in connection with cachexia and senility. It occurs in heart muscle, in liver and in skeletal muscle of old dairy cows. The pigment is not seen as such, but it imports a brownish tinge to cardiac and skeletal muscles. If the affected parts can be radically removed, the carcass may be passed for food. If the brown atrophy is generalized, the carcass must be condemned.

311.13 The disposition of bled carcasses that have been left unopened an unusually long time due to a breakdown, careless handling, or other exigency is affected by many factors, such as the size of the carcass, external temperature, kind and amount of content of stomach and intestines, and the period of delay in evisceration. It is therefore impossible definitely to fix time limits that will determine the disposition of the carcass. The distinction between local or superficial absorption of intestinal gases and the changes produced by actual or incipient putrefaction in the tissues must be taken into account. It may be possible to remove the first, but not the second.

Therefore, it is imperative that disposition be based on post-mortem findings rather than on the length of time the carcass is left unopened. In many cases it is desirable to delay final disposition until the retained carcasses have been thoroughly chilled and inspection made part by part. The above does not void the time limit required in Section 310.16 of the regulation pertaining to hyperimmune swine.

311.14 All specimens of diseased tissues should be sent for examination to the Pathology Laboratory. Inspectors should be encouraged to use the laboratory to obtain information necessary for making proper disposition.

Naturally, the ante-mortem and post-mortem findings must be considered along with the report of histological examinations. Materials for packing and forwarding specimens, such as 10 percent formalin solution, microscope slides for

Section 311.14

blood smears, bottles, mailing tubes, and franks should be readily available to all veterinarians who need these supplies. No specimens other than those packed in 10 percent formalin solution should be forwarded for examination except when a laboratory diagnosis is necessary to determine the disposition of a carcass or parts from a nonreactor animal suspected of having tuberculosis, a portion of the specimen should be placed in borax. The ratio of solution to tissue should be 2 to 1.

311.15 Completion of the reverse side of Form MI-402-2, Identification Tag—Ante-Mortem, to show the disposition of the suspect on post-mortem examination may be a duplication of work since these findings must be recorded on Form MI-403-6, Report of Final Post-Mortem Inspection of Retained Carcasses. Form MI-402-2 is a station record used primarily to convey information from the ante-mortem inspector to the final post-mortem inspector, and use of the reverse side of the form to record post-mortem disposition is not required. However, it may be used for this or other purposes if the Officer in Charge thinks it is necessary.

311.16 All cases of *Cysticercus Cellulosae* or cases that resemble this condition in swine must be confirmed by the laboratory. All information concerning the identification and origin of the animals should be collected. When the diagnosis is confirmed, the information should be reported to the veterinarian in charge of the state and the appropriate state livestock sanitary official in the state of origin on Form ANH-2-11C. Also, if the origin can be determined, the Public Health official in that area should be notified.

311.17 In preparing Form MI-403, Ante-Mortem and Post-Mortem Inspection Summary, the actual slaughtering time for the species involved should be recorded by the final inspector in the block provided. The actual slaughtering time does not include so-called coffee breaks, change-over times (from one species to another), breakdowns, walk-offs, etc.

311.18 Carcasses of animals affected with icterus are to be disposed of according to Section 311.20 of the Regulations. Icterus should not be confused with yellow fat conditions characteristic of certain breeds of livestock.

311.19 Carcasses of swine that give off a pronounced sexual odor shall be condemned. The meat of swine carcasses that give off a sexual odor less than pronounced may be passed for use in comminuted cooked meat food products or for rendering. Boneless pork meat from such carcasses may be shipped in containers labeled such as "Boar Meat Passed for Use in Comminuted Cooked Product Only." These properly labeled containers bearing marks of inspection may be shipped without restriction. Carcasses or bone-in cuts from such carcasses may be shipped from the establishment under restriction (325.9 of the Regulations and Manual) to other federally inspected establishments either for boning, packaging, and labeling as previously described in this paragraph or for processing in the federally inspected establishment in a comminuted cooked product.

311.20

A. A practical test for carotenosis may be made by placing a white paper towel or napkin on a cut surface of the liver. An orange-bronze stain is indicative of the condition.

B. "Slight" may be construed to mean that the lesions are to be not only small in size but also few in number.

C. If the conditions are so localized that minimum amount of trimming will change the appearance from "Moderate" to "slight," the organ may be trimmed and passed without restriction.

311.21 Carcasses of animals which are designated as "recovered" cases of anaplasmosis may be passed for food if the yellow coloration of the carcass disappears on chilling and if no other lesions of the disease are present.

311.22 Attention is called to possible lesions resulting from antibiotic injections found on post-mortem inspection of cattle carcasses. The antibiotic may have been administered to alleviate or disguise acute symptoms of disease or as a preventive measure but in any event, the animal is often marketed prior to complete absorption of the oil base antibiotic. Several instances have been reported where the lesions were observed in the round or heavy muscular parts of the carcass. The lesions are described as an oily viscous material, opaque yellow in appearance. Assay of tissues in our Meat Inspection Laboratory has demonstrated therapeutic levels of antibiotics in the meat and edible organs in these cases.

In case lesions are discovered on post-mortem examination, tissue samples should be submitted for analysis. Samples should include muscle and fat taken at the site of the injection (including the injected substance when present), liver tissue, kidney tissue and muscle derived from an unaffected part of the carcass. Each tissue sample should be identified and placed separately in plastic bags. Approximately one-half pound of each tissue will be adequate for assay analysis. Do not add borax or formalin to tissue samples in which antibiotic findings are requested. The sample should be frozen, wrapped, and packed with dry ice (also wrapped in paper and sealed to prevent direct air contact), mailed by regular airmail with a distinctive air-mail legend and addressed to the Pathology Laboratory. Normally, samples prepared in this manner, mailed during the week, will arrive in satisfactory condition.

It has been found that trimming of affected areas may or may not assure that the carcass and organs are free of antibiotic residues. Each carcass showing lesions of injections suspected of being caused by antibiotics should be retained and disposed of in accordance with laboratory findings. If the establishment desires confirmation by collect wire, indicate this information on the sample form.

To assist in reducing error in the assay and aiding in trace-back on antibiotic injections, we would like to have all available information known

Section 311.22

regarding the case accompany the laboratory sample, i.e., ante-mortem symptoms, origin of animal number in lot, number of animals affected, antibiotic suspected, dose, manufacturer's product name, etc.

311.23 The carcasses of animals affected with the following conditions may be used for carnivorous animal foods provided they are freely slashed and decharacterized: Anasarca, nonsystemic arthritis (after removal of affected joints), Ocular Squamose Cell Carcinoma (after removal of neoplastic tissue), emaciation, eosinophilic myositis, immaturity, nonseptic bruises and injuries (after removal of abnormal tissues), sarcosporidiosis, and unborn calves. This permission should be granted with the understanding that all parts used will be promptly handled, freely slashed, and adequately decharacterized by charcoal or dye as required by the Officer in Charge. The slashing, decharacterizing and packing of the product should be accomplished in an inedible area under the supervision of an inspector. Facilities must be adequate so that the carcasses or parts to be used for animal foods are not contaminated with pus, manure, septic or toxic materials and the like. The operation must not result in a nuisance within the establishment.

311.24 Biological Residues in Meat and Meat Food Products - Instructions and Standards of Compliance. The Meat Inspection Regulations (Sections 301.1(cc), 309.19, 311.42, and 318.18) formalize general policies and provide for standards and procedures which are intended to assure that meat and meat food products from animals slaughtered and/or processed under Federal meat inspection are free of harmful residues or within safe tolerances, and are wholesome and fit for human food. Instructions and standards of compliance to make this determination will provide the inspector information to properly carry out his responsibilities.

311.25 Biological Residues in Meat.

A. Chlorinated Hydrocarbon Pesticide Compounds. The chlorinated hydrocarbon pesticides accumulate and are stored in the fat of animals which makes them of concern from a residue standpoint. The chlorinated hydrocarbon pesticides include: aldrin, benzene hexachloride, chlordane, dieldrin, DDT, and its metabolites (DDE and TDE), endrin, heptachlor, lindane, methoxychlor, and toxaphene.

1. Ante-Mortem Symptoms - Chlorinated Hydrocarbon Pesticide Poisoning. The chlorinated hydrocarbon pesticides act as stimulants or depressants of the central nervous system with neuromuscular symptoms usually occurring such as restlessness, muscular spasms, stiff and exaggerated gait, and convulsions. The onset of symptoms varies depending on the exposure dose and chemical involved, but most animals will show symptoms within the first twenty-four hours after exposure. In severe poisonings following a convulsion, the animal may appear very depressed or become comatose several hours before death. In acute poisonings a rise in body temperature is observed.

2. Post-Mortem Findings - Chlorinated Hydrocarbon Pesticide Poisoning. In animals showing acute poisoning, the lesions are nonspecific. Usually petechial hemorrhages occur in the heart and areas adjacent to large

blood vessels. Generally, the lungs are congested and show some hemorrhages. In poisoning resulting from oral administration, gastroenteritis has been observed. In chronic cases similar lesions occur, together with degenerative lesions of the liver and kidneys.

B. Organo-Phosphorus Pesticide Compounds. The organo-phosphorus pesticides all contain the phosphorus radical in a combination which permits the pesticide to inhibit acetylcholinesterase and other cholinesterases. The organo-phosphorus pesticides include: parathion, methyl parathion, ronnel, malathion, ethion, dioxathion (Delnav^R), mevinphos (Phosdrin^R), and naled (Dibron^R).

The biological action results from an excess of acetylcholine at nerve endings where it functions as a transmitter. Accumulation of acetylcholine leads first to stimulation and later to paralysis of all nerve synapses and motor endings, except the termination of the sympathetic fibers.

1. Ante-Mortem Symptoms, Organs, Phosphorus Pesticide Poisoning. Generally, animals first show excessive salivation. Respiratory difficulties may be observed. Restlessness and stiffness occur. Death may be due to blocking the airways by accumulation of mucous in the constricted bronchi, acute pulmonary edema or respiratory failure. Convulsions are seen only with very high doses. Variable symptoms result from individual animal susceptibility, chemical used, and degree of exposure. Susceptibility in individual animals also is due to their cholinesterase reserve before exposure to the organo-phosphorus pesticide.

2. Post-Mortem Findings - Organo-Phosphorus Pesticide Poisoning. In acute poisoning resulting from a cholinesterase-inhibiting pesticide, the lesions are never pathognomonic or particularly outstanding. Hemorrhages in the heart, lungs, or gastro-intestinal tract have been observed. Congestion of the lungs with signs of pneumonia may also be observed.

C. Fungicides. The fungicides are widely used in the treatment of seed grains. Treated seed grains have been diverted without approval for feeding food animals. The practice at this time is not considered safe and residue tolerances in meat and edible organs from animals fed treated seed grains have not been established. Some commonly used fungicides are: Captan, Thiram, Ceresan M^R, and Zineb.

1. Ante-Mortem Symptoms - Fungicide Poisoning. Evidence of acute poisoning, especially in sheep, may include excessive nasal discharge, colic, diarrhea, stilted gait, rapid respiration, depression, and coma just before death.

2. Post-Mortem Findings - Fungicide Poisoning. The lesions are not very specific, but excessive blood-tinged fluid may be present in the abdominal and thoracic cavities. Degenerative changes can occur in the liver and kidneys. Hemorrhages in the heart, lungs, and gastro-intestinal tract have been reported.

D. Inorganic Lead, Arsenic, Mercury, and Selenium.

1. Ante-Mortem Symptoms - Metallic Element Poisonings. In acute arsenical poisoning, the most prominent ante-mortem symptoms are salivation, thirst, vomiting, colic, diarrhea, staggering gait, coma, and paralysis. Lead or mercury poisonings are often associated with symptoms involved with central nervous system disorders. Intoxications associated with selenium involve varied symptoms and lesions, but the two syndromes requiring special attention are "blind staggers" and "alkali disease."

2. Post-Mortem Findings - Metallic Element Poisoning. The principal lesions in arsenic poisoning are inflammation, edema, ruptured blood vessels, and necrosis found in the gastro-intestinal tract. There may be a diffuse inflammation of the liver.

Hemorrhagic gastro-enteritis and degeneration of the liver are present in acute lead poisoning with subepicardial and subendocardial hemorrhages a constant finding. In chronic lead poisoning, the liver is yellow in color with marked degeneration of the lobules. Extensive degeneration of the kidneys is common.

The caustic action of mercury may give to the mucosa of the mouth, tongue, pharynx, and esophagus a cooked appearance. Hemorrhages in the lungs, kidneys, and liver are frequently observed. The blood is dark red and coagulates slowly. In chronic mercury poisoning, the abdominal organs are pale and the heart is enlarged due to anemia.

In chronic selenium poisoning, fibrosis and atrophy of the liver, heart, and kidneys are observed. Erosions of the articular surfaces of the long bones may be found.

E. Veterinary Drugs - Used for The Treatment and Prevention of Diseases.

1. Ante-Mortem Findings. Drugs used as feed additives, hormones, tranquilizers, anthelmintics, antibiotics, etc., serve a useful purpose when properly used. It is possible, however, that apparently healthy animals might be unsuitable for food purposes because of possible masking of symptoms of disease conditions. The ante-mortem inspector must be alert to the possibility of drugs masking the symptoms of a sick animal. Examples of these are the use of tranquilizers in certain nervous system diseases and the use of antibiotics in the disease conditions associated with pyrexia.

Swellings in the gluteal or other heavy muscle regions, discolorations in the regions of the body orifices, pronounced medicinal or chemical odors, and other abnormalities associated with the administration of drugs are important aspects of ante-mortem inspection.

2. Post-Mortem Findings. Lesions in the muscles, discoloration of the subcutis tissues, and characteristic medicinal, chemical, or other foreign odors are possible post-mortem findings associated with drug residues.

F. Submission of Tissue Samples for Biological Residue Analysis. The Livestock Slaughter Inspection Division's biological residue surveillance program is actively monitoring the tissues of food animals for the presence of biological residues. The surveillance program consists of an objective and a selective phase. The objective phase is designed to randomly select and analyze animal tissues for chemical, drug, and pesticide residues. The number of samples collected and analyzed in the objective phase is proportionate to the number of animals slaughtered in federally inspected plants located in each Meat Inspection District.

The selective phase consists of the analysis of tissue samples for a specific chemical, drug, or pesticide in conjunction with regulatory control action necessary to eliminate a biological residue which, if present in the edible tissues of an animal, would make it unfit for human food.

1. Tissue Samples for Chlorinated Hydrocarbon Pesticide Analysis. The tissue for chemical analysis for chlorinated hydrocarbon pesticides shall consist of one pound of fresh fat. The tissue should be frozen and shipped to arrive at the laboratory in good condition. Preservatives should not be used. Form MI-422, Sample for Laboratory Inspection, should be used for all requests for chlorinated hydrocarbon pesticide analysis. For the objective phase of the surveillance program, include on the MI-sample form the species and origin of the animal. In the selective phase, add to the MI-sample form any history and ante-mortem and post-mortem observations that indicated a poisoning may be involved. The tissue analysis is performed by the field Chemical Control Laboratories.

2. Tissue Samples for Organo-Phosphorus Pesticide Analysis. The tissue for chemical analysis for the organo-phosphorus pesticides shall consist of one pound each of fresh liver and muscle. Each of the fresh tissues should be placed in a separate plastic bag to prevent the transfer of a residue from tissue to tissue during shipment. The tissues should be frozen and shipped to arrive at the laboratory in good condition. Preservatives should not be used. An analytical method is not available to identify the entire group of organo-phosphorus pesticides and the inspector should, if possible, designate a particular organo-phosphorus pesticide to aid the laboratory in making a chemical determination on the tissue submitted for analysis. Form MI-422, Sample for Laboratory Inspection, should be used for all requests for organo-phosphorus pesticide analysis. For the objective phase of the surveillance program, include on the MI-sample form the species and origin of the animal. In the selective phase, add to the MI-sample form any history and ante-mortem and post-mortem findings that indicated a poisoning may be involved. The tissue analysis is performed by the field Chemical Control Laboratories.

3. Tissue Samples for Inorganic Lead, Arsenic, Mercury, and Selenium. The tissues for inorganic lead, arsenic, mercury, and selenium shall consist of one pound each of fresh fat, muscle, liver, and kidney. Each of the fresh tissues should be placed in a separate plastic bag to prevent the transfer of a residue from tissue to tissue during shipment. The tissues

should be frozen and shipped to arrive at the laboratory in good condition. Preservatives must not be used. A single analytical method is not available to identify all metallic elements, and the inspector should indicate the metallic element the evidence indicates may be involved. Form MI-422, Sample for Laboratory Inspection, should be used for all requests for inorganic lead, arsenic, mercury, and selenium analysis. For the objective phase of the surveillance program, include on the MI-sample form the species and origin of the animal. In the selective phase of the program, add to the MI-sample form any history and ante-mortem and post-mortem findings resulting from the poisoning. The tissues for lead, mercury, and selenium analysis is performed at the Chemical Control Laboratory, Washington, D. C. The tissues for arsenic analysis is performed at the field Chemical Control Laboratories.

4. Tissue Samples for Veterinary Drug Analysis. The tissues for veterinary drug analysis shall consist of one pound each of fresh muscle from the injection lesion, liver, kidney, and muscle taken from a distant site in relation to the injection lesion. Each of the fresh tissues should be placed in a separate plastic bag to prevent the transfer of a residue from tissue to tissue during shipment. The tissues should be frozen and shipped to arrive at the laboratory in good condition. Preservatives should not be used. Form MI-403-8, Pathological Laboratory Request Report, should be used for all requests for veterinary drug analysis. Include on the MI-sample form all necessary information such as species and origin of animal, any history, and ante-mortem and post-mortem findings that indicated a veterinary drug residue may be present in the animal's tissues. The tissue samples are analyzed for veterinary drugs at the Microbiology Laboratory, Beltsville, Maryland.

5. Tissue Samples for Histopathological Examination. In determining the wholesomeness of the edible tissues of animals in the selective phase of the surveillance program, tissue samples (1/4 to 1/2 inch thick) of heart, liver, spleen, kidney, brain (cerebellum cerebrum, medulla, brain stem), and all abnormal tissues should be fixed in 10 percent buffered formalin solution immediately after post-mortem inspection. The fixed tissues should be submitted to the Pathology Laboratory, Beltsville, Maryland, for histopathological examination.

Form MI-403-8, Pathological Laboratory Request Report, should be used and the species and origin of the animal, any history, and ante-mortem and post-mortem observations that indicated a poisoning should be included on the MI-sample form.

G. Dispositions of Carcasses and Parts. All carcasses and parts of carcasses of animals suspected of being poisoned with a chemical, drug, or pesticide shall be retained on post-mortem inspection pending a disposition from the Livestock Slaughter Inspection Division in Washington, D. C.

H. Samples of Import Meat Products for Residue Determination. Circuit residue monitoring programs include samples of imported meat for residue

analysis. Form MI 422-2, Import Sample for Laboratory Inspection, should be used. Identify the product, country of origin, and the establishment. Submit import residue samples to the Chemical Control Laboratory servicing your Circuit.

311.26 Disposition of Cattle Carcasses Affected with Nerve Sheath Tumors. These are relatively common tumors in the bovine and are usually seen in adults. From a Meat Inspection standpoint, it is practical to group Schwannomas (neurilemmomas) and neurofibromas in a single category. These tumors arise from the sheaths covering the peripheral nerve trunks; that is either the sheath of Schwann (neurilemma) or the perineurium.

The sheath of Schwann (neurilemma) is a delicate membrane which surrounds the axon of the individual nerve fiber while the perineurium is the connective tissue sheath around a bundle of nerve fibers. In medullated nerve fibers, the axon is surrounded by myelin, and when tumors arise from these nerve sheaths, they may contain a soft jelly-like substance.

On post-mortem examination, the tumors may occur as single or multiple growth though usually many growths are found. They may be found along any nerve trunk in the body; however, the most common sites are the heart, brachial plexus, intercostal spaces, paravertebral areas, mediastinum, and coeliac plexus. Careful dissection usually can demonstrate a nerve trunk associated with the tumor. The tumors are nodular and appear encapsulated and vary considerably in size. They are white, may be either hard or soft, and gelatinous. When the gelatinous type occurs in the heart, it may be mistaken for a viable tapeworm cyst.

Microscopically, the tumors are composed of fibroblastic tissue with the cells arranged in interlacing bundles and whorls supported in either a collagenous or mucinous stroma.

The tumor cells are generally well differentiated fibroblasts and there is little or no evidence of anaplasia or mitosis. The lack of invasiveness is a good criterion in considering this to be a benign tumor. However, the slow growing tumor tissue may sometimes encompass adjacent tissue and give a false appearance of malignancy. This is particularly true in the heart where the contractions may tend to draw the muscle fibers into the tumor.

When more than one tumor is found in a carcass, they are of multicentric origin and have not spread by metastasis. This is similar to multiple warts on the skin.

In the disposition of a carcass affected with nerve sheath tumors, one must consider the systemic effect of the tumor on the health of the animal. Experience shows that though systemic effect resulting from these tumors is infrequent, the effect is usually the result of mechanical interference with function. For example, a carcass with multiple tumors but failing to show any significant systemic effect should be passed for food after removal and condemnation of all abnormal tissues. On the other hand, a carcass with this tumor, but showing evidence of cachexia, should be condemned.

PART 313 - TANK ROOMS AND TANKS

313.1 Tanking equipment such as tanks, melters, conveyors, handtrucks, etc., must be provided to assure prompt and efficient handling of inedible and condemned material. The doors between edible departments and inedible or condemned departments shall be solid, self-closing doors, snug-fitting double action doors or an effective air screen. Inedible and condemned material should not be allowed to accumulate from one day to the next unless emergency conditions exist. Pipes, chutes, conveyors, etc., used to convey material from edible to inedible departments must be effectively hooded and vented. Inspectors must be aware of the origin, destination, and purpose of all pipelines, chutes and conveyors. Inedible products containers must be watertight and distinctively marked. The marking system should be uniform and consistently applied on all such containers used in an establishment. Inedible containers must be acceptably clean before being allowed to enter edible departments.

313.2 Requests from official establishments to bring dead animals on official premises shall be directed to the District Director.

313.3 Some factors that are considered in granting permission to bring dead animals on the premises of an official establishment are adequate and suitable rendering facilities; acceptable means of conveying the dead animals to the tank charging level; ability of the establishment to promptly handle and tank the dead animals in addition to inedible and condemned material usually present at the establishment; and whether the receiving and handling of dead animals is likely to create a nuisance.

PART 314 - TANKING AND DENATURING
CONDEMNED CARCASSES AND PARTS

314.1 Retained or condemned tag numbers of condemned animals, carcasses and products, tank seal numbers, the time of sealing and breaking of seals and the identity of the inspector should be recorded on the daily tanking form, MI-406-2.

314.2 In addition to denaturants listed in 314.4 of the Regulations, the following product may be used to denature condemned carcasses and parts: FD&C No. 3 green dye with citronella and detergent. The basic preparation is made by using one part FD&C No. 3 green dye, 40 parts by weight of water, 40 parts liquid detergent and 40 parts citronella. This basic concentrate is further diluted by using one part concentrate to 32 parts of water.

The denaturants should be used in sufficient quantity to render the product unfit for human food.

Kerosene, denaturing oil or No. 2 fuel oil should not be used to denature condemned carcasses or product.

314.3 The skinning of unborn calves shall be permitted only in enclosed areas of inedible departments. These areas shall be similar to retained cages and shall be sealed by an inspector when the cage is in use and not under direct supervision of an inspector. Any collection or handling of unborn calves, including the collecting of fetal blood or other laboratory specimens, shall be performed in these enclosed areas under positive control of an inspector. When research or educational material is being collected from unborn calves, no products other than those specified on Form MI-403-10 are to be removed from the sealed areas.

314.4 Requests for permits to obtain specimens of diseased, condemned or inedible materials for educational, research or other nonfood purposes should be referred to the Officer in Charge. Inspectors should ask agents collecting these specimens to show them their permit (Form MI-403-10) before allowing specimens to be collected.

314.5 The removal of inedible and condemned denatured material which may be infectious or contain disease organisms is of concern to state officials responsible for animal disease control. When this material is moved interstate, the officials of more than one state will be involved. Establishments desiring to remove inedible and condemned denatured material shall obtain a letter from the animal disease control officials of the states involved stating that removal of the material is acceptable. This letter indicating acceptance should be obtained annually. One copy should be kept in the local Meat Inspection office and a copy should also be forwarded to the Officer in Charge.

314.6 Establishments desiring to save condemned material for fish or animal food shall have separate equipment acceptable to the Officer in Charge

Section 314.6

for this purpose. These operations shall not create a nuisance or interfere with inspection. Records should be kept by the inspector to assure that the proper temperatures and holding periods are maintained on fluke-infested livers.

PART 315 - RENDERING CARCASSES AND PARTS INTO LARD,
RENDERED PORK FAT, AND TALLOW, AND OTHER COOKING

315.1 Carcasses and parts passed for cooking should be held under strict control at all times. Trucks and containers used to hold and convey product passed for cooking should be conspicuously marked and equipped with a sealing device.

315.2 Edible rendered fats containing tank water in first stages of sourness may be reprocessed if the handling is begun promptly after its detection. There is no provision for rehandling for food purposes rendered fats that contain tank water beyond the first stages of sourness. The fats may not be mixed with sound edible product in any proportion as a recovering process. The product should be retained until further approved processing determines its final disposition. Treatment of rendered fats may be undertaken immediately without waiting for a report from the laboratory.

315.3 Cod, kidney, and breast fats bearing the marks of Federal inspection may be admitted into official establishments for edible purposes provided the fats are clean, sound, and otherwise fit for human food.

315.4 Salt used to settle rendered fats should be free from extraneous material that indicates contamination with filth but may contain insoluble mineral matter that does not remain in the rendered fat.

315.5 Partially defatted beef fatty tissue and partially defatted chopped beef manufactured by low temperature rendering processes require the use of acceptable raw materials, prompt chilling, and subsequent freezing of the residue. The process will not destroy or inactivate bacterial contaminants nor will the physical appearance and character of the residue always reflect the true contamination level in all cases. To insure production of sound products of this type, the following safeguards must be followed:

A. The raw material must be in excellent condition. The condition of the fat or product should demonstrate its recent production and handling under proper sanitary conditions and refrigeration. Any soilage or physical condition detracting from its proper handling would make it ineligible for use in the production of these types of products.

B. Raw product handled in establishments other than federally inspected establishments is not eligible for use in manufacturing these products.

C. The raw product must have been refrigerated and maintained under refrigeration at 50° F. or less. Killing floor fats moving directly to the process need not be refrigerated.

D. The partially defatted product should leave the refrigeration cycle of the process at 40° F. or less.

Section 315.5(E)

E. The partially defatted product should be rapidly frozen so as to be solidly frozen within a 6-hour period, unless used immediately in product.

Samples of the partially defatted chopped beef or beef fatty tissue should be sent to the Microbiology Laboratory for the purpose of evaluating the inspectional controls of the establishment. The samples should be frozen and packed to prevent defrosting in transit.

315.6 Partially defatted beef and partially defatted chopped pork may only be manufactured from beef and pork, respectively, not from beef fat nor from pork fat. Each individual piece of meat cuts or trimmings used in manufacturing these partially defatted meat products must contain at least 12 percent lean meat. This shall be determined by a practical knife-cutting separation of the lean from the fat tissues. Samples should not be sent to the Meat Inspection Laboratories for fat analysis.

PART 316 - MARKING, BRANDING, AND IDENTIFYING PRODUCTS

316.1 Material submitted by establishments through the Officer in Charge or his designated representative for approval by the Technical Services Division should be carefully examined to insure that it meets the requirements of the applicable Regulations.

Only legible imprints of required markings should be submitted for approval or use in an official establishment. Approval of the marks of inspection appearing in newspaper advertisements, billboards, and the like is not necessary; although, if the opportunity is afforded to preview such matter locally, the markings should conform to the standards. The mark of Federal inspection should not be used in such advertisements in a misleading way.

316.2 The establishment will be required to furnish all brands, including replacements, as they become necessary. When received, new brands should be delivered immediately into the custody of a Department employee and the approval and use of these brands should be in accordance with the Meat Inspection Regulations.

316.3 Brands bearing the inspection legend should be uniform in size and design and in the exact form of the official brands.

316.4 The control of brands includes those brands held in supply or storage rooms as well as those in service. The owner or operator of an official establishment must make arrangements with the Officer in Charge to carry this out.

316.5 Property records of metal brands bearing the inspection legend are no longer maintained. It is not necessary to report lost or unserviceable brands to Washington. Unserviceable brands should be properly defaced and disposed of at the Circuit, except when the 2-½ inch rubber brands mounted on aluminum handles which are furnished by the Department become unserviceable, the aluminum handles should be returned to the Meat Inspection Administrative Staff in Washington for reuse.

316.6 Whether lost or unserviceable brands should be immediately replaced by the establishment is a matter to be determined by the Officer in Charge. He determines the number of brands needed to properly meet requirements at the establishment involved.

316.7 An up-to-the-minute inventory of all brands bearing the inspection legend, whether in use or in storage, should be maintained as prescribed by the District Director.

316.8 Application of the marks of inspection to clothing, walls, posts, and the like must be discouraged. Brands bearing the marks of inspection or other marks should be kept clean while in use. A clear legible imprint of an approved brand cannot be made with a worn or mutilated brands. So-called grade brands, buyers' brands, and marks signifying rabbinical inspection

Section 316.8

should be placed so as not to obliterate, or be confused with, required markings.

316.9 The legibility of the marks of inspection has been improved in some cases by drilling two small holes (about one-sixteenth inch in diameter) through the face of the hot-iron brands to permit the escape of steam that forms when the hot brand comes in contact with the wet surface of product. The use of cast steel burning brands results in improved and more legible inspection legend imprints on cured products.

316.10 Only approved branding ink should be used. Purple branding ink is composed of "FD&C Violet No. 1 dye, water, alcohol, and sugar." Acetone may be added to shorten drying time. Marking pencils containing FD&C No. 1 dye should be used for marking meat cuts and carcasses.

316.11 A hot ink brand equipped with a thermostatic control to regulate the temperature of the electrically heated burning element greatly improves branding on meat, meat byproducts, and meat food products. Ink for hot brands may be prepared without sugar; an acceptable dye and specially denatured alcohol 23A (alcohol plus 10 percent of acetone) may be used if desired.

316.12 Official grading terms such as Prime, Choice, Good, Standard, Commercial, and Utility, and the letters AA, A, B, and C, which are associated with these official grades of meat of cattle, sheep, and calves, may be used in official establishments only on meat graded as such by an official representative of the Federal Meat Grading Branch.

Wholesale and retail cuts derived from carcasses bearing an official grade designation may be identified with the same grade designation as appears on the respective carcass from which the cut is derived.

These instructions do not apply to the terms "Army-AA," "Army-A," "Army-B," or similar terms applied to meats or the package thereof in conjunction with the standard Army veterinary inspection stamp by inspectors of the United States Army.

316.13 Impressions of grade markings applied to meat in official establishments under the supervision of an official representative of the Federal Meat Grading Branch need not be submitted to the Technical Services Division for approval. However, such impressions should be approved by the Officer in Charge prior to use. Grade markings, other than official markings, should be submitted to the Technical Services Division for approval in the usual manner.

316.14 After carcasses are washed and clothed, each half should be legibly marked "U. S. Inspected and Passed."

316.15 Carcasses conditionally passed for food on account of *Cysticercus bovis* as prescribed in Section 311.24(f) of the Regulations may be marked with the inspection legend and establishment number at the time they are placed in a freezing compartment maintained under lock or seal.

316.16 Calf carcasses shipped from one official establishment to another with the skin attached may be marked at the second establishment after the skin has been removed with the receiving establishment's number and inspection legend. This in no way relieves the responsibility of placing legible brands on each quarter of the carcass at the originating establishment. Cuts taken from carcasses marked at another official establishment may be branded with the inspection legend and identifying number of the official establishment in which the fabrication is done.

316.17

A. It is not practical to designate the location and number of brand imprints to be applied on carcasses because of variations in local conditions and in the further processing of the carcass. More than the required minimum marks of inspection may be placed on carcasses as local circumstances warrant.

B. The No. 1 brand (1-3/4 inch diameter) shall be used for branding cattle and hog carcasses. The No. 2 brand (1-1/4 inch diameter) shall be used for calf carcasses. The No. 3 brand (3/4 inch diameter) shall be used for sheep and goats, and loins and ribs of pork.

316.18 Beef tenderloins should be individually marked with the inspection legend and establishment number before they leave the official establishment.

316.19 Pork stomachs are considered meat byproducts rather than animal casings even though intended for use as containers of meat food products.

316.20 The use of metal clips or staples to affix labels or tags to meat food products is not permitted because of the possibility of metal inclusion in product.

316.21 Form MI-408-1 properly modified to describe clearly the product transported may be used to cover the shipment of product to be further processed as provided for in Section 316.13(a) of the Regulations. This form is to be used, of course, in addition to the certification required in Part 325 of the Regulations.

316.22 If not otherwise specified, statements such as "cereal added," "nonfat dry milk added," "artificially colored," and the like should be placed on the product or on material to be attached to the product, in the order in which the additions normally are made in processing the article.

316.23 It is not practical to state specifically the exact size or weight of products customarily sold at retail intact. Factors that must be considered are: Class of product, geographical distribution, customer expectancy, etc.

316.24

A. Branding the word "tender" or any of its derivatives on heated and smoked pork products may be done only at the establishment at which the processing takes place. The product is subjected to sufficient heat to attain an internal temperature of at least 140° F.

B. Use of the term "Cooked," "Fully Cooked," "Thoroughly Cooked," "Ready-to-Eat," or "Ready-to-Serve" on heated and smoked pork product is acceptable only when the processing results in the product exhibiting the usual characteristics of a fully cooked article, such as partial separation of the meat from the bone, easy separation of the tissues, and a cooked color, flavor and texture throughout the product. This usually requires a minimum internal temperature of 148° F. Proposals for the use of these terms should be accompanied with the full description of the process and internal temperature attained when the marking material is submitted for approval.

316.25 Soluble seasonings consisting of spice extractives having a distinct red color, such as extract of paprika, should not be used in fresh meat products such as hamburger, fabricated steaks, cubed beef, meat patties, etc., because of the color enhancing properties of the seasoning. If these soluble spice extracts are used in the formulation of cured sausage and other meat food products, the amount used should be controlled so that the color of the finished product will not be significantly different from that of a product prepared with the same ingredients but without the soluble spice extract.

316.26 When tags, tissue strips, brands, and the like are used to apply the list of ingredients, only applicable required markings should be included thereon. However, if nonrequired features are added, then all applicable required labeling features should be shown. To illustrate: If the name of the product is added on a tag bearing the list of ingredients in bologna, that side of the tag bearing the two features should be completed by adding the name and address of the firm.

316.27 The identity of all ingredients through all stages of fabrication of a meat food product must be maintained.

316.28 When cured meats are used as part of a fabricated product for which minimum meat requirements have been established, consideration should be given to the amount of added substances in the cured meat when calculating the formula on the fresh weight basis.

316.29 Smoked meats such as ham or bacon used in fabricated product may be declared as "Smoked Pork," or "Ham," or "Bacon," as the case may be in the list of ingredients. Such declarations will insure the smoked product as included is identified.

316.30 The domestic meat label should be placed on shipping containers enclosing a combination of inspected product and food articles other than meat products.

316.31 If an immediate or true container serves also as a shipping container, the marks of inspection, as well as the other required features, should be applied.

316.32 Markings other than the inspection legend and establishment number, applied to shipping containers by stencils, pencil marks, or in print, may be used with the approval of the Officer in Charge. Such markings must not be

false or misleading. They may be used in addition to required markings but not in lieu thereof.

316.33 Domestic meat labels that have become detached from the shipping container of federally inspected product may be replaced with domestic meat labels of the receiving official establishment to facilitate further shipment after proper identification of the product has been made.

316.34 The marking required on the shipping container of inedible rendered fat need not be submitted to the Technical Services Division for approval.

316.35 Packaged meat of foreign origin which is repackaged under Federal meat inspection shall be identified as to the country of origin on the new package. When meat in carcass form of foreign origin is separated into cuts which normally have an inspection legend, they shall be marked to show the country of origin adjacent to the marks of inspection. Product resulting from usual boning operations in official establishments need not be kept separate from domestic product for identification.

316.36 The carcasses of animals injected with papain shall be marked with the statement "Tendered with Papain." These markings shall be applied in a continuous manner by means of a roller brand along the round, loin, rib, neck, chuck, and foreshank and from the flank region over the flank, plate, rib, and brisket. Imprints of such roller brands should be forwarded for approval if not already approved.

PART 317 - LABELING

317.1 Although there is a connection between Parts 316 and 317, each part is a separate and distinct entity. Both deal with the identification of product; Part 316, by application of lettering or affixing of tags or labels directly to the product, and Part 317, by the labeling of the immediate cover or container. In some instances, the fulfillment of the requirements of Part 317 eliminates the necessity of compliance with Part 316. In a broad sense, labeling requirements are to assure that a true and clear picture of the product is available to the consumer.

317.2 No reference to Federal meat inspection is permitted on labeling material except as it is embodied in the inspection legend.

317.3 Large containers such as tierces, drums, barrels, and fiberboard boxes which enclose loose or unpackaged product are true containers and as such must be labeled. Whether or not all markings are applicable depends on the kind of product. It is not practicable to apply a statement of ingredients to a container enclosing more than one type of fabricated product. See the marking requirements imposed by Part 316.

317.4 Labeling may consist of a combination of printing, stenciling, box dyes, and the like, for large-size true containers and for shipping containers. Crayons, marking brushes, and the like, are not acceptable for applying any required labeling features to such containers except the figure indicating the quantity of contents.

317.5 While stencils, box dyes, and labels for large-size true containers and for shipping containers may be used with the provisional approval of the Officer in Charge, the inspection legend in any form must be approved by the Technical Services Division.

317.6 Empty containers bearing only approved markings and intended for federally inspected product may be used for display or advertising purposes without approval of the Technical Services Division.

317.7 Properly labeled or marked product may be covered with loosely woven stockinet, provided the marks are plainly visible through the covering.

317.8 The establishment number may be embossed on either the bottom or cover of hermetically-sealed containers.

317.9 The establishment number should be embossed and the date of canning should be shown by code or otherwise on the metal caps for hermetically-sealed glass containers of products fully processed within such containers. The identity of the contents should be shown in a similar manner when such identity cannot be positively established by other means. These features can be legibly and permanently applied with permanent ink, such as lithographer's ink, and a mechanical stamping device immediately after the cap is affixed to the glass container.

317.10 Labels used directly on and in connection with meat food products may be, and on occasion have been sources of contamination. For example, water-soluble or fat-soluble ink used in printing labels may become transferred to the product. The paper or other substances constituting the label may contaminate the product through disintegration, presence of soluble components, or the like.

It would not be practicable for the Technical Services Division to control or anticipate such misuse of labels, even though it does in some instances, pick up probable objectionable conditions. The only adequate control is the supervision over labels exercised by inspectors at establishments. Inspectors should, therefore, take precautions to assure that a label offered for use at an establishment is:

- A. Approved in accordance with the Regulations.
- B. Used on the product for which it is applicable as set out in terms of the approval and in the Regulations concerning the composition of the product.
- C. Placed on product or container in such manner that all of the required features appear on the principal display panel.
- D. Used on product which offers sufficient contrast in color so that the required features printed on transparent coverings are prominently displayed.
- E. Printed with permanent ink; all of the required features being clearly legible.
- F. Such as will not result in contamination of the product.

317.11 An inspector can readily see ink that has been transferred to the product or a label that has disintegrated or corroded. However, he faces a different problem with substances used in the manufacture of plastics and paper coatings. Generally, manufacturers of plastic films, coatings, and containers present to the Technical Services Division samples of their materials and a statement of their composition in order to have their acceptability determined before making deliveries to inspected establishments. If the inspector has a question concerning the acceptability of such materials, he should send a sample of the material, with all identifying marks, the name and address of the manufacturer, and any other pertinent information, to the Technical Services Division for advice. Aluminum foil (containing no lead) is acceptable from a toxicity standpoint for use in direct contact with product; although when in contact with well salted product, corrosion may take place to an extent that would make its use undesirable.

317.12 A standard of composition has been identified for each product for which a label has been approved. These standards of composition include the minimum meat content and in some instances they identify the maximum amount of water, binder, extenders, fat, and other meat or meat byproduct that may be used.

Many of the standards are contained in the Meat Inspection Regulations and some appear in Meat Inspection Memorandums. Others are not published but are made effective through our label control program by the approval or disapproval of labels. When labels are submitted for approval for a product for which a standard of identity has not been published, it must be accompanied by the formula and a complete description of the product's preparation so that the person reviewing or supervising the use of the label may determine if the label is intended for, and is used on, product complying with its standard of composition.

Samples of new products and products on which there is a question as to whether they are classed as meat food products should be submitted to the office of Standards Group, Technical Services Division, Consumer and Marketing Service, United States Department of Agriculture, Washington, D. C. 20250. Information should be furnished regarding the name of the product and a full description of the method of preparation, with the ingredients and their percentages. If the samples are perishable, they should be packed in dry ice or otherwise protected so that they will arrive in a wholesome condition.

A. "Salisbury Steak" is a cooked product prepared with chopped beef and may contain not more than 25 percent pork and/or veal. It may also contain whole eggs and extenders, substances such as bread crumbs, cracker meal, cereal, nonfat dry milk, and reconstituted skim milk.

B. In many establishments product labeled "Sliced Cooked Ham" is derived from canned ham identified as "Cooked Ham, With Natural Juices, Gelatin Added."

Upon removal of the product from the can and preparing the ham for slicing, the free juices and a portion of the gelatin are discarded. It must be noted, however, that a portion of the gelatin remains in the seams, and in some cases on the surface of ham. It, therefore, should be required that cooked sliced ham derived from canned hams be labeled "Sliced Cooked Ham, Gelatin Added" to properly identify the product.

C. Chopped Ham and Pressed Ham may use shank meat as an optional ingredient to the extent of not more than 25 percent over that normally present in boned ham. A figure of 12 percent shank meat has been adopted as representative of boneless whole ham. An additional allowance of 25 percent would, therefore, equal 3 percent of the whole ham ingredient. Determine first the weight of the whole ham ingredient in each batch of chopped ham and allow the addition of 3 percent of this weight in shank meat.

317.13 Inspectors should report all new processing methods to the Technical Services Division. The report should include new types of equipment and merchandising practices that might have an effect on the character of the finished product or affect standards of composition and labeling.

317.14 When deciding on a common name for a product, the consumer's knowledge rather than that of the meat industry should be considered. For instance, in the packing industry "picnic" is the common name for a product, but since it is not well known to the public as such, it should be described as a "pork shoulder picnic" in order to identify it adequately. The name of the product applies to the finished article; the ingredients are listed in the order of the quantities used in the preparation of the products.

317.15 When fried pork skins are prepared from skin removed from smoked pork bellies, names such as "fried pork skins," "fried bacon skins," or "fried bacon rinds" may be used to designate the finished product. When labeling material is submitted for approval, the kind of skin used in the product should be stated.

317.16 If the term "spice" or "spices" is used in the list of ingredients, it must refer to whole or ground natural spices. Spices may, however, be covered by the general term "flavorings" in the list of ingredients.

317.17 When the term "farm style" or "country style" is used in connection with sausage, the product must be prepared with natural spices to the exclusion of oleoresins, essential oils and other spice extractives. Sugar is the normal sweetening agent for "farm style" or "country style" sausage.

317.18 Although nearly every ingredient in a product contributes to its flavor, such substances as parsley, pistachio nuts, pimentos, and pickles which are not added to a product solely for flavoring purposes must be specifically named.

317.19 Pimento is applicable to allspice, whereas pimienta refers to the coneshaped thickwalled Spanish sweet pepper. Other varieties of sweet peppers, such as the common bell-shaped variety, are listed as sweet peppers.

317.20 The following applies in listing the ingredients used in the preparation of meat food product:

A. The terms "pork," "beef," "veal," "mutton," and "goat meat" are acceptable regardless of the anatomical derivation of the meat, except that tongues and hearts should be specifically named; for example, pork tongues and beef hearts. A declaration such as "beef cheeks" or "pork cheeks" should be used for untrimmed cheeks; that is, cheeks with the glandular material attached. The Technical Services Division may require specific declaration for meat ingredients on labels for certain products such as chili con-carne, chili con-carne with beans, canned beef hash, ham spread, and fabricated fresh meat items (hamburger, chopped or ground beef, and "steaks").

B. Meat byproducts such as beef tripe, pork stomachs, pork livers, and pork fat should be individually declared, as such.

C. The designation "boned pork heads" is applicable to meat and meat byproducts from pork heads provided the relative amount of muscle tissue is not less than that normally present on pork heads.

D. The term "cereal" is acceptable to denote one or more meals or flours derived from cereal grains without more specific declaration. Bean flour, soya flour, or potato flour should be declared by name because they are not classed as cereal.

E. The foregoing should not be construed to invalidate approval of labels bearing more specific ingredient declaration than those mentioned in A, C, and D, nor to prevent the use of such designation when desired by the establishment.

F. Dehydrated onions, dehydrated garlic and dehydrated celery used as seasoning agents may be shown as onions, garlic or celery as the case may be.

G. Either of the terms "Corn Syrup" or "Corn Syrup Solids" may be used as an ingredient identification on labeling material for meat food products to reflect the use of either corn syrup or corn syrup solids.

H. Pork fat should be declared as such in the statement of ingredients. As a guide for judging the distinction between pork and pork fat, skinned pork jowls may be declared as "pork" but clear fatbacks and clear shoulder plates must be declared as "pork fat."

I. Ingredients such as cracker meal, macaroni, and similar substances which in themselves are fabricated from various ingredients may be declared as such instead of listing the individual component parts.

J. When two meat ingredients comprise at least 70 percent of the meat and meat byproduct ingredients of a formula and when neither of the two meat ingredients is less than 30 percent by weight of the total meat and meat byproducts used, such meat ingredient may be interchanged in the formula without a change being made in the ingredient statement on labeling materials, provided that the word "and" in lieu of a comma shall be shown between the declaration of such meat ingredients in the statement of ingredients.

K. When unskinned pork jowls are used in the preparation of a meat food product, they shall be reflected in the statement of ingredients as "Unskinned pork jowls" and the product shall not be identified as "All Meat."

L. Dehydrated onions (chips) and dehydrated potatoes used as a component rather than a seasoning agent should be listed as dehydrated onions and dehydrated potatoes.

M. Onions, garlic and parsley used as such should be listed as onions, garlic and parsley in the ingredient statement.

N. Powdered onions, powdered garlic, and powdered parsley may be declared as flavoring.

O. In the list of ingredients spice extractives may not be listed as spices, but may be listed as flavoring.

P. "Cheese" unqualified may be featured in the name of the product which will be reflected in the ingredient statement by its recognized standard of identity, such as, Pasteurized Process Cheese. However, showing "cheese" unqualified in the ingredient statement refers to "Cheddar" cheese only.

317.21 The term "Center Cut" may be used in connection with labeling material for pork loins from which the shoulder end has been removed by cutting crosswise to the length of the loin at a point posterior to the edge of the scapular cartilage and from which the ham end of the loin has been removed by cutting crosswise to its length anterior to the cartilage on the tuber coxae.

The term "Center Cut Pork Chops" may be used to identify chops cut from any portion of a center cut pork loin.

317.22 Trimmings derived from the cheek and the tongue shall be shown as follows:

A. "Salivary glands, lymph nodes and fat (cheeks)," preceded by the name of the species from which derived, to identify the tissues resulting from converting "cheeks" to "cheek meat."

B. "Tongue trimmings," preceded by the name of the species from which derived, includes the entire mass of tissue, except cartilage and bone, obtained through converting long-cut tongues to short-cut tongues by a transverse cut posterior to the epiglottis removing the soft palate and epiglottis, cutting through the hyoid bone leaving approximately $1\frac{1}{2}$ inches in length of the bone with the tongue.

C. "Salivary glands, lymph nodes and fat (tongues)," preceded by the name of the species from which derived, to identify the resulting mass when the muscle tissue is removed from tongue trimmings. The muscle tissue may be designated by the specific species from which derived.

D. Trimmings derived from the tongue itself should be identified as "tongue meat," preceded by the name of the species from which derived. Tongue meat should not include any of the tissues described in paragraphs B and C of this section.

317.23 Shortening prepared with a mixture of meat fats and vegetable oils may be identified either as "Shortening Prepared with Meat Fats and Vegetable Oils" or "Shortening Prepared with Vegetable Oils and Meat Fats" without regard to the order of predominance of the fats and oils used, provided that there is a significant amount of the lesser ingredient used.

317.24 If the firm can be located through a telephone or city directory, the label need not include the street address; the city, state, and postal zip code are sufficient.

317.25 (Reserved)

317.26 Vienna sausage packed in water or brine or similar products in size 208 x 208 can should be 4 ounces net weight.

317.27 In determining compliance with the Regulations, the inspector should see that all wrapping and packing materials are not included in the net weight.

317.28 A statement of the gross and tare weights in lieu of the net weight on such containers as tierces, barrels, drums, boxes, crates, and large-size fiberboard containers is acceptable.

317.29 Meat and meat food products in casings need not be marked with a statement of quantity of contents; however, space may be provided on the casing for applying the weight such as an opaque area preceded by the words "Net Weight." If the casings are marked with a statement of quantity of contents, the inspector should check to see that such statements are accurate.

317.30 Frankfurters, wieners, pork sausage and breakfast sausage may be packed at catch weights. When these commodities are not packed at uniform weights of 8 ounces, 12 ounces or 1 pound, the statement of quantity of contents should be shown with the same degree of prominence as the other required labeling features, including the name of the product.

Customarily, containers for shingle-pack sliced bacon are rectangular in shape and hold quantities of 8 ounces, 1 pound and 2 pounds. Deviations from these standard weights are acceptable when the net weight statements are accorded prominence equal to the most conspicuous label feature, including the product name, and are separated from other features and printed in a color of ink contrasting sharply with the background.

The same requirements apply to meat pies when in square containers and the quantity of contents vary from the usual 8 ounces.

317.31 Systematic controls should be maintained by the establishment at all times to check the quantity of contents. Deceptive filling of containers must not be permitted, even though a correct statement of the quantity of contents is shown.

317.32 In most cases, the net weight can be determined at the time of packing. However, in some instances, especially on imported products and products such as canned frankfurters, the net weight of the completely processed articles is checked. To insure a uniform method of determining net weight, the following procedure is outlined:

A. The weight of the unopened can is tabulated as the gross weight.

B. The weight of the clean, dry can is tabulated as the tare weight.

C. The difference between the gross weight and the tare weight equals the net weight.

317.33 After checking the net weight of several cans, it is possible to determine the net weight of additional cans without opening them by subtracting the average tare weight from the gross weight of the unopened can. However, enough cans should be opened to establish a tare that is representative of the lot. The number of cans necessary to establish a reliable average tare depends on the uniformity of the can weights. If the difference in weight between the lightest and heaviest of the first six cans opened is no more than $1/8$ of 1 ounce, the average of the first six cans will probably suffice as an average for the lot. If the difference in weight between the lightest and heaviest is approximately $3/16$ of 1 ounce, six more cans should be opened. This refers particularly to cans having a capacity of approximately 12 ounces. The tare weight of larger cans may vary in proportion. Each lot of product should meet the following requirements:

A. The average net weight of the cans checked should equal at least the stated net weight.

B. There should be as many cans that are overweight as are underweight.

C. The underweight should equal the maximum tolerance on not more than 20 percent of the total. (The incidence in a hundred cans of a very few containing a small quantity below the maximum underweight with the average at least equaling the stated net weight is not sufficient to reject a lot if the other net weight requirements are met.)

317.34 If a canned meat food product consists entirely of material that is nutritious and suitable for food, the statement of net weight should include the total weight of contents.

However, if the canned meat food product is prepared with a packing substance not customarily used for foods such as water, brine, or agar, then the stated net weight should be the weight of the meat or meat food product, exclusive of packing material, taken after the article has been packed several days. For example, the stated net weight of pigs' feet in vinegar pickle should be the drained weight of the pigs' feet and the stated net weight of whole ox tongues in agar should be the weight of the ox tongues exclusive of agar. Some products, such as cooked pigs' feet, cooked lamb tongues, and cooked sausage, may be packed in a vehicle at such weight as to result in regaining the moisture that has been lost in cooking before the product leaves the establishment.

317.35

A. The following underweight tolerances are allowable for comminuted products and for liquid and partly liquid products in which the liquid is included in the net weight:

For a 6-pound can -----3/4 of 1 ounce
For a 4-pound can -----1/2 of 1 ounce
For a 2-pound can -----3/8 of 1 ounce
For a 1-pound can -----5/16 of 1 ounce
For a 12-ounce can -----1/4 of 1 ounce
For an 8-ounce can -----3/16 of 1 ounce
For a 6-ounce can or less -----1/8 of 1 ounce

B. The overweight tolerances for comminuted products and for liquid and partly liquid products in which the liquid is included in the net weight are allowed as follows:

For a 6-pound can -----2½ ounces
For a 4-pound can -----2 ounces
For a 2-pound can -----1½ ounces
For a 1-pound can -----1 ounce
For a 12-ounce can -----3/4 of 1 ounce
For an 8-ounce can -----1/2 of 1 ounce
For a 6-ounce can or less -----3/8 of 1 ounce

C. The overweight should not result in an overstuffed appearance of the can. Overstuffed cans should be handled in accordance with the Regulations. The following net weight tolerances are applicable to frankfurters packed in brine in consumer-size cans:

- 1. The overweight should not exceed the weight of one whole link.
- 2. The average net weight should equal the stated net weight.
- 3. No underweight should exceed 4 percent of the stated net weight.

D. The average net weight for the large institutional-size cans should equal the stated net weight. The overweight should not exceed 2 percent of the stated net weight and the underweight should not exceed 1 percent of the stated net weight.

E. When a specific number of units of meat or meat food product are declared on the label as a component of a meat food product, (e.g., "10 meat balls," "Approximately 60 franks," or a TV dinner vignette illustrating 2 slices of beef, etc.), the following is the procedure for determining compliance:

Range Including the Declared or Illustrated Count	Permitted Minimum Count in 1 Container	Permitted Maximum Count in 1 Container
2-9	Declared Count	Declared Count Plus 1
10-15	Declared Count	Declared Count Plus 2
16-21	Declared Count	Declared Count Plus 3
22-27	Declared Count Minus 1	Declared Count Plus 3
28-33	Declared Count Minus 2	Declared Count Plus 3
34-40	Declared Count Minus 2	Declared Count Plus 4

Range Including the Declared or Illustrated Count	Permitted Minimum Count in 1 Container	Permitted Maximum Count in 1 Container
41-47	Declared Count Minus 3	Declared Count Plus 4
48-53	Declared Count Minus 3	Declared Count Plus 5
54-60	Declared Count Minus 4	Declared Count Plus 5
61-67	Declared Count Minus 4	Declared Count Plus 6
68-74	Declared Count Minus 5	Declared Count Plus 6
75-80	Declared Count Minus 5	Declared Count Plus 7
Over 80	Declared Count Minus 6	Declared Count Plus 7

This criteria is not applicable to a count of units representing the entire contents of the package (e.g., "20 beef patties").

The maximum limits are not applicable when the number of units illustrated on a label would not necessarily be intended to represent the entire contents of a particular ingredient (e.g., chunks of beef in the vignette of a beef stew label).

When the number of units is declared on the label as a count range (e.g., "65-75 meat balls," etc.), the permitted minimum and maximum counts in one container will be the extremes of the declared range.

Acceptance Criteria for Lot Inspection

LOT SIZE		Sample Size	Permitted No. of Containers Below Minimum Limits	Permitted No. of Containers Exceeding Maximum Limits
No. 3 Cyl. (404 x 700) Containers or Smaller	Containers Larger than No. 3 Cyl. (404 x 700)			
2,400 or less	1,200 or less	3	0	0
2,401- 12,000	1,201- 7,200	6	0	1
12,001- 24,000	7,201- 15,000	13	0	2
24,001- 48,000	15,001- 24,000	21	1	3
48,001- 72,000	24,001- 36,000	29	2	4
72,001-108,000	36,001- 60,000	38	2	5
108,001-168,000	60,001- 84,000	48	3	6
168,001-240,000	84,001-120,000	60	3	7
Over 240,000	Over 120,000	72	4	8

Acceptance Criteria for On-Line Inspection

When numerous samples are checked by establishment quality control, use the above criteria as a guide to the number of deviations above and below the permitted range during a shift. When plant quality control is reliable and effective and the product is infrequently out of compliance, government sampling may be reduced to occasional verification sampling during the day.

Checking for net weight and meat ingredient weight compliance will be in addition to the count declaration; however, the same containers may be used as required for the respective samples.

317.36 The mark of inspection in whatever approved form it may appear is the symbol of our service that reaches the public intimately. It erases from the consumer's mind the question of whether the product on which it appears has been subjected to complete inspection. It is our certification that the product has been carefully inspected and found to be sound, wholesome, and fit for human consumption at the time of shipment and that the labels are not deceptive or misleading. Therefore, we should take great pride in its significance and exercise constant vigilance in its application.

317.37

A. The master label file system in the Technical Services Division consists of a combination of microfilm and International Business Machines card records.

Each label with all material pertinent thereto is photographed. To keep the photographic work at a minimum and for uniformity in photographing labels and other material presented in connection with requests for approval, we ask that you adopt a form for transmittal of sketches and labels illustrated at the end of Part 317. For use in the Technical Services Division, one copy of the label material being presented for approval should be attached to the transmittal form with only one staple. Mount all other copies to the transmittal form in any manner that suits your needs. Do not, however, cover the space provided for the approval stamp. Establishments should prepare a supply of the form for their own use on 8 x 10½ size paper. Your cooperation will assist greatly in the operation of the master label file and will be appreciated.

B. To increase the efficiency with which labeling materials are received, and approved or disapproved labels are dispatched from the Technical Services Division and to eliminate unnecessary label files, the following procedures will apply.

1. Submission of sketches and finished labels.

a. General instructions.

(1) Each copy of a sketch or finished label must be mounted on a transmittal form (See Fig. 14 - Agriculture Handbook 190 or Section 317.37 - Manual of Meat Inspection Procedures of the United States Department of Agriculture). Forms will be provided by the establishment, firm, or importer.

(2) Sketches or finished labels for products for which a standard of identity has not been published must be accompanied by a complete formula and detailed description of the method of preparation of the copy of the transmittal form. Such information is not generally required for products for which a standard of identity has been published; however, this may not always be true.

2. Labeling material for domestic products.

a. General instructions - this material may be submitted:

(1) Through the Officer in Charge or an inspector designated by the Officer in Charge.

(2) Through central label office of the firm or corporation.

(3) By personal visit of establishment or firm representative or agent to the office of Meat Labels and Packaging Group, Technical Services Division.

b. Requirements to apply for each method of submittal:

(1) Through the Officer in Charge; four copies of sketch or final label accompanied by Form MI-442 executed by an inspector of the Department.

(2) Through firm's central label office; four copies of sketch or final label, plus one or more as required by firm's label office. This method is limited to those firms or corporations who maintain a central label office, and who have received permission from the Director, Technical Services Division to submit labels directly.

(3) By personal visit of representative or agent; four copies of sketch or finished label, plus one or more as required by firm or representative. Submittal must be accompanied by Form MI-442 executed by an inspector of the Department.

3. Labeling material for import products.

a. General instructions.

(1) Only two sketch labels are required. Two finished labels are required, plus one additional for each port of entry through which the product is to be offered for import inspection.

4. Request for extension of temporary approvals.

a. General instructions.

(1) All requests for extension of temporary approvals must be directed, in writing, to the Meat Labels and Packaging Group. The requests must clearly identify label approval number, date of temporary approval, product name, quantity of labels on hand, quantity of labels used since grant of temporary approval or last grant of extension, and estimated time required to exhaust supplies. It is not necessary to submit the labeling material concerned unless the expiration date has passed.

(2) Labels for domestic product. Request must be forwarded to the Meat Labels and Packaging Group through the Officer in Charge for any comments or recommendations that are appropriate.

(3) Labels for import products. Request should be forwarded through the Officer in Charge at the ports of entry for any comments or recommendations that are appropriate.

5. Approval duplication requests.

a. General instructions.

(1) Labels for Domestic Products. Request for stamp of duplicate approval should be forwarded through the Officer in Charge, making reference to the approval number and date of approval for the labels involved. Sufficient copies of the label should be furnished to satisfy required distribution.

(2) Labels for Import Products. Request for stamp of duplicate approval should be furnished making reference to the approval number and date of approval on the transmittal form for the label concerned. Sufficient copies of the label should be furnished to effect distribution to the ports of entry having interest. The labels sent for duplicate approval must be exactly like the labels previously approved.

6. Distribution of approved labeling material and label correspondence by the Technical Services Division.

a. General instructions.

(1) Approved sketches and finished labels for domestic products. Two copies of sketches or finished labels will be sent to the office of the inspector at the establishment. The inspector will retain one copy for label files maintained in the Meat Inspection office located in the establishment and deliver the second copy to the appropriate establishment official. Copy or copies will be distributed by the Technical Services Division to firm's central label office when such request is on file.

(2) Approved sketches and finished labels for import product. One copy will be distributed to the office of the import inspector for each port requested. One copy will be distributed to the importer or agent submitting request for approval.

7. Distribution of disapproved sketches or finished labels and correspondence by the Technical Services Division.

a. General instructions.

(1) One copy will be retained in the files of the Meat Labels Group of Technical Services Division in Washington. Remaining copies will be returned to establishment or firm, along with correspondence regarding action taken.

Copies of correspondence will be forwarded to the Officer in Charge.

8. Maintenance of label files at field station.

- a. Label files will be maintained only in the Meat Inspection office at the establishment. Files will be maintained as required by Section 317.60 of this Manual.

317.38 If the Technical Services Division stamps an addition on labels that are approved, it constitutes a condition or requirement that becomes a part of the approval.

317.39 Attention is directed to a difference in the marking and labeling requirements for imitation sausage. Since it is apparent what product is being imitated, it is sufficient to apply the single word "Imitation" directly on the product as set forth in Part 316, but Part 317 requires that the word be followed by the name of the sausage imitated and the statement of ingredients. Except that imitation sausage packed in properly labeled containers having a capacity of one pound or less, and of a kind usually sold at retail intact, need not bear the mark "Imitation" on each link or piece, provided no other marking or labeling is applied to each link or piece. The container should be labeled in accordance with Part 317 of the Meat Inspection Regulations.

317.40 Where certain fixed minimum or maximum quantities of particular ingredients are prescribed in the composition of designated product, it is the responsibility of the inspector in the department to obtain strict adherence to the requirements. Laboratory analysis may be obtained when necessary. The ingenuity of the inspectors may be taxed at times to determine the percentage requirements. It entails a thorough knowledge of the product and its preparation. Company figures alone should not be relied on.

317.41 If the term "bacon" is used to describe a product other than the conventional item prepared from the side of a swine carcass, it should be qualified as to its origin in terms such as "pork shoulder plate bacon."

317.42 Product designated "Dry Salt Cured" may contain a curing solution that was injected directly into the tissues but not through the circulatory system before it is covered with dry curing mixtures. It may be momentarily moistened to facilitate initial salt penetration. However, the term does not apply to product placed in curing solution. Product identified as "Dry Cured" should not be injected with curing solution or processed by immersion in a curing solution.

317.43 Tongues and brains of sheep and lambs are practically indistinguishable and may be designated either sheep tongues or lamb tongues and sheep brains or lamb brains. Large calf livers and hearts may be designated beef livers and beef hearts.

317.44 Gelatin is not a permitted ingredient of sausage, luncheon meat, meat loaves, and the like.

317.45 There is a clear difference between a loaf prepared with meat to the exclusion of meat byproducts and labeled as meat loaf, beef loaf, pork loaf, or similar name and a comparable product fabricated from various combinations. Nonfat dry milk and soya flour must be declared as part of the name of the product as well as included in the list of ingredients on a label for a product called "meat loaf," "pork loaf" or the like. The word "loaf" refers to a form in which the product is prepared rather than to a specific article of food, and when used to designate a product, it must be followed by the list of ingredients.

317.46 "Chopped beef" should consist of chopped fresh beef without the addition of beef fat as such and the product should not contain more than 30 percent of fat.

317.47 Ham cooked in the conventional manner, which does not include the use of boiling water, should be labeled "cooked ham" not "boiled ham."

317.48 When the term "shankless" is used in reference to a ham, it indicates the shank has been removed by means of a cut through the joint at a right angle to the femur bone. The distal tip of the semitendinosus muscle may be severed above its tendinous attachment leaving an extension approximately two inches in length. This extension is considered to be an integral part of the body of the ham and is usually folded over the end of the femur.

317.49

A. "Detached skin" refers to portions of skin from which most of the underlying fat has been removed, such as skin removed from bacon intended for slicing and skin removed in the process of closely skinning hams, shoulder cuts, and fat backs. If the removal of portions of skin is incidental to the removal of a considerable proportion of the underlying fat from the ham, shoulder, back or the like, preparatory to the rendering of such fat, then the portions of skin so removed should not be regarded as detached skin and may be included with the fats and rendered into lard. Ham facings are not regarded as detached skin.

Fresh ham skins, fresh pork shoulder picnic skins, and the like may be used in the rendering of lard when, taken as a lot, they have at least 65 percent of trimmable fat.

B. "Tails" mean the skin-covered portion only.

C. "Windpipes" include the larynx, trachea, and bronchi.

D. "Scrap fat" includes particles of tissue such as may be collected as a result of splitting the carcass, sawing the carcass or parts, and washing blood-stained parts. It does not include fatty tissues of the thoracic, abdominal, and pelvic cavities, the trimmable fat attached to the organs in such cavities, or the particles of fat that may be scraped from the surfaces of the three cavities, provided the fatty tissues are reasonably free from muscle tissue, blood, and large blood vessels.

Section 317.49(D)

Fresh, clean, sound fat obtained in the fleshing of fresh pork skins may be rendered for lard.

E. "Skimmings" include unrendered fatty tissues and rendered fat such as may be collected from receiving vats under rendering tanks or from cooking vats.

F. "Settlings" include "bottoms" such as accumulations of "scrap," water, and other material and the rendered fat therewith from receiving, settling, and storing vats.

G. "Pressings" include the following:

1. Fat pressed from the residue incident to rendering lard, other than by steam rendering, may be regarded as lard if it is promptly made sufficiently free of sedimentary scrap and water. Fat pressed from residue incident to rendering lard, including steam rendering, shall not be rerendered for lard-making purposes. Such fat may be re-rendered for rendered pork fat-making purposes.

2. Fat pressed from the residue incident to rendering rendered pork fat, and fat pressed from the residue incident to rendering lard, may be regarded as rendered pork fat if it is promptly made sufficiently free of sedimentary scrap and water. Fat pressed from the residue incident to rendering rendered pork fat may be re-rendered to make rendered pork fat.

317.50

A. Unpressed residue incident to rendering lard and rendered pork fat, other than by steam rendering, may be re-rendered for rendered pork fat-making purposes. Unpressed residue incident to rendering lard and rendered pork fat shall not be re-rendered for lard-making purposes.

B. Pressed residue incident to rendering open kettle rendered lard and open kettle rendered pork fat, which has not been pressed by means such as an expeller or a hydraulic press, may be re-rendered for rendered pork fat-making purposes. All other pressed residue incident to rendering lard and rendered pork fat shall not be re-rendered for edible purposes.

317.51 The term "refined lard" is applied to open-kettle rendered, prime-steam, or dry-rendered lard that has been run through a filter press with or without the addition of a bleaching agent.

317.52 When the term "manteca" or "manteca pura" is used as a name of a product, the English designation "Lard" or "rendered pork fat," as the case may be, should follow in close proximity.

317.53 The terms "chili" and "chili con carne" may be used synonymously and the terms "chili with beans" and "chili con carne with beans" may be used synonymously.

Tripe and untrimmed cheeks are not customary ingredients of chili con carne. Although beef heart meat is permitted in chili con carne, beef hearts are not.

To insure adequate identification, the following names will be used for the "Beef Heart" product described:

- A. "Beef Hearts" - untrimmed with bone intact.
- B. "Beef Hearts - Bone Removed" - untrimmed with bone removed.
- C. "Beef Heart Meat" - beef hearts with auricles (heart cap) and bone removed.

317.54 Pork stomachs, pork skins, pork snouts, and other meat byproducts, except fat, are not customary ingredients of a product labeled "Braunschweiger." The name "liver sausage" is inaccurate for a product prepared with meat byproducts to the exclusion of meat.

317.55 For an inspector to exercise proper inspectional control over the labeling of meat and meat food products, it is necessary that he have a clear understanding of the applicable Regulations and be thoroughly familiar with the preparation and composition of each product prepared under his supervision.

317.56 The name used to designate an article should be the common name, if any, and one which clearly describes the finished product; for example, a product labeled "beef and gravy," "pork and gravy," "pork with barbecue sauce," "meat balls with gravy" or the like should contain more meat or meat balls than gravy or sauce in the finished product. If upon examining representative samples of the finished product the inspector finds more gravy or sauce than meat, names such as "gravy and beef," "gravy and pork," "barbecue sauce with pork," and "gravy with meat balls" would be accurate and informative.

317.57 The statement of ingredients should show the ingredients listed in the order of their percentages according to the amounts used in preparing the product rather than in the order of predominance in the finished product. For example, cooked sausage may contain 10 percent added water; however, it is customary to use a greater amount of water in its preparation. In such case, water should be declared in the statement of ingredients in the order of its predominance by comparison with the other ingredients.

317.58 Potted and deviled meat food product should not contain added moisture, but when water is used to replace the moisture lost incident to precooking some of the meat or meat byproduct ingredients, then water constitutes an ingredient of the product and should be declared according to the quantity used.

317.59 It is the responsibility of the inspector to see that all meat and meat food products prepared under his supervision are properly labeled.

An approved label bearing a product or ingredient origin statement may be used by an establishment only when the inspector has determined that the statement is accurate in all details whenever used. If the inspector is unable to attest to the accuracy of the statement, it is his duty to withhold usage of the label.

The procedures used by the inspector for this determination must assure accuracy without resulting in significantly increased inspectional controls or inspectional routines in addition to those normally required to assure compliance of product with the regulations.

The establishment has the responsibility for accuracy of labels containing product or ingredient origin statements. Each such label proposed for use should be accompanied by a complete description of means of determining the accuracy of the claims when submitted for approval.

The assigned inspector should review the label and indicate his acceptance of the description of the means identified by the establishment. If the means are sufficient to assure accuracy of the statement without resulting in significant increase in inspectional determinations and controls, the inspector should so indicate. The label and description should then be submitted to the Officer in Charge for his concurrence and then forwarded to the Labels and Standards Staff for review.

317.60

A. A uniform label filing system to aid inspectors wherever assigned is outlined below. Labeling and marking material should be filed in regular filing cabinets as follows:

1. A separate file is maintained for each official establishment.
2. The material is filed in chronological order with the last approval in front.
3. The files are subdivided alphabetically with material filed under the appropriate letter according to the name of product; For example, under B -- bacon, bologna, brains, braunschweiger, ground beef, corned beef, pork shoulder butt, beef and gravy; under C -- capocollo, cervelat, cutlets (pork, veal, etc.), chili con carne; under M -- luncheon meat, meat food product (potted, deviled, etc.); under P -- pepperoni, prosciutti, pudding (liver, tongue, blood, etc.); under S -- shortening, steaks, pork sausage, polish sausage, vienna sausage, soups; and under T -- tongue, thuringer, tails (pig, ox, and ox tail joints). Material that cannot be readily classified alphabetically is filed under "miscellaneous." Very few items should fall in this class. No other subdivision of the file is necessary, and no distinction is made in the various types of labeling material, such as inserts, wrappers, brands, etc. All correspondence pertaining primarily to labeling or marking devices should be filed with the material with which it is concerned. If a letter concerns more than one label, a cross reference is noted on the label.
4. Labeling and marking material that has been granted approval for a limited period is filed separately from regularly approved material in order to facilitate removal from the files at termination of approval period.
5. Material approved in sketch form is filed separately from regularly approved or limited approved material. To keep the number of sketch approvals on hand to the minimum, sketches should be discarded when finished material prepared in accordance with the sketch is approved.
6. No card or other index system is necessary when labels are filed under the above system.
7. Each official establishment office is furnished SRS-6 (10-1-62), Meat Inspection Label Cards, for the approved labels being used by the establishment and from time to time this office will send to the official establishment office additional SRS-6 (10-1-62) cards to cover recently approved labels.
8. To rescind an approved label, the management of the establishment needs to mark an "R" on the corresponding SRS-6 (10-1-62) card and return it to the Officer in Charge, who will forward it to the Technical Services Division. This should be done as the labels become obsolete. Do not submit lists of labels to be rescinded, as we need the IBM cards in order to pull our corresponding IBM Filmsort cards from our files. Where a packer maintains a duplicate file of approved labels in its central office the SRS-6 (10-1-62)

cards may, at the request of the management of the establishment, clear through that office. However, the Officer in Charge should know what labels are being rescinded.

Exception: SRS-6 (10-1-62) cards covering labels with temporary approval should be destroyed as the time limit expires.

Whenever an SRS-6 (10-1-62) card covering an obsolete label is returned to the Technical Services Division, the label is to be considered as rescinded. When sufficient SRS-6 (10-1-62) cards have accumulated to warrant making tabulations on our IBM machines, rescinded lists will be mailed to the stations.

9. At small establishments, such as slaughtering plants where only a few marking and labeling devices are used, it is generally satisfactory to file all approved material chronologically in one jacket without subdivisions.

10. Mounting of labels, inserts, etc., on thin manila or cardboard sheets, 11-3/4 by 9 inches or 11 by 8½ inches in size, before filing, aids greatly in keeping the material in good condition and also makes an orderly and neat file. The approval number and date of approval can be written on the upper righthand corner of the manila sheet if it is not readily visible on the label.

The Officer in Charge should see that the label files in his Circuit are set up in accordance with the system just described.

317.61 The term "Veal Cutlet" denotes a single slice of veal taken from the round. The thickness of the slice can vary; however, combining several thin slices is not permitted when the term "Veal Cutlet" is used.

317.62 Monosodium glutamate and hydrolyzed plant protein may be used as ingredients of sausage, meat loaf and luncheon meat, as well as other products.

317.63 Monosodium glutamate or hydrolyzed plant protein may be used in products such as hamburger, chopped beef, cubed steak, and steak prepared from meat that has been molded after comminuting processes such as grinding, chipping, thin slicing, and the like.

317.64 The labels for meat food products containing monosodium glutamate or hydrolyzed plant protein should not show the word "artificially flavored" contiguous to the name of the product.

317.65 All questions relating to a product's amenability to the Federal Meat Act and the Regulations should be referred to the Technical Services Division for answer. Full information should be submitted including the method of preparation of the article, the ingredients used and their proportions, the name of the product, and a sample thereof if it can be obtained. Further information should be given relative to whether the article is intended for interstate or foreign commerce.

317.66 Product derived from carcasses of animals injected with papain such as liver, heart, tongue, cheek and head meat, trimmings, boneless beef, tenderloins, tails, tripe, and cuts of meat not showing an imprint of the roller brand reading "Tendered with Papain" shall be properly identified and kept separate from other product. When such product leaves the official establishment, the immediate container shall bear a label showing, in addition to other required labeling, a statement such as "Tendered with Papain" or "Treated with Papain" prominently displayed contiguous to the name of product. The kidneys must be segregated, keeping them properly identified to be used for animal food or tanked.

The establishment will furnish retail dealers handling such product with labels bearing the statement "Tendered with Papain" displayed in a prominent manner contiguous to the name of product for use by such dealers on consumer packages or product derived from the carcasses of animals injected with papain. Compliance and Evaluation personnel and other inspectors who may visit retail markets should observe the effectiveness of this phase of the labeling program. Should they find any retail outlets not following through with this identification, the facts should be immediately reported to the Technical Services Division.

317.67 It has been determined that the use of transparent or semitransparent wrappers or coverings bearing red lines, red scatter print, or other red graphic material in a manner so that the lines, print, or graphic material are positioned over the entire surface of the package gives a false impression of the color of certain products. This is contrary to the provisions of Section 317.8(c)(5) of the Meat Inspection Regulations.

Transparent or semitransparent wrappers or coverings as described above for use in packaging of cured, cured and smoked, or cured and cooked sausage products, and sliced meat food products must provide for at least 50 percent of the total product surface being visible through a wrapper or covering that is free of color, print, or graphic material, to insure that the actual color of the product is easily recognized.

317.68 When an artificial sweetner is used in curing hams or bacon, the product shall be marked and labeled to show its presence. A statement, such as "Sodium Cyclamate, an Artificial Sweetner Added" shall be prominently displayed contiguous to the name of the product wherever shown on the container. If an artificial sweetner is used along with sugar it will be necessary to show the presence of the sugar on the label in addition to the statement showing the presence of the artificial sweetner.

Director, Technical Services Div. Washington, D.C.		FOR USE OF THE WASHINGTON OFFICE, TECHNICAL SERVICES DIVISION		
For Approval (check one)		RECEIVED STAMP	APPROVED STAMP	DISTRIBUTION STAMP
Final	Sketch			
For use until				
Date Sketch Approved				
Est. No.				
Type of Material: Such as Casing Wrapper, Carton, etc.				
Formula and Method of Preparation				
Remarks:				
Sig. of Est. Representative		Date		
Officer in Charge		Date		

PART 318 - REINSPECTION AND PREPARATION OF PRODUCTS

318.1 When product has become unclean by accidental contamination and can be cleaned with water, care must be taken to see that pieces are promptly washed individually under a spray of running water. Separate equipment should be provided for this purpose. Use of hand-washing basins for cleaning product is not permitted. Unclean articles referred to in this paragraph must not be accumulated before or during the washing operation.

318.2 It may be necessary to heat or otherwise treat products that are suspected of having absorbed odors that are not readily discernible by usual methods of examination.

318.3 Unclean frozen product should be made clean in an acceptable manner before being defrosted in water or pickle. Care must be exercised to see that no loose material from containers is allowed to enter the defrosting solution.

318.4 All product that is condemned and destroyed for food purposes on reinspection should be reported on Form MI-407 so that the inspection requirements as well as the facilities necessary for disposal of condemned material can be determined. Unclean paunches, stomachs, chitterlings, and unrendered fat are examples of products that are frequently retained and the establishment decides to dispose of the material as inedible rather than spend the necessary labor to place it in acceptable condition. In such cases, the action taken by the inspector in retaining the product is equivalent to a decision that the product is condemned unless it is cleaned or otherwise made acceptable for food purposes. Such product should then be reported as condemned on reinspection. An estimate of the weight is acceptable.

318.5 Particles of bone in meat food products is a source of consumer complaints and should be guarded against by close inspection. Some of the products in which bones or particles of bone may be found include the following: Tongue trimmings, brains, cheek meat, hearts, trimmings derived from neck bones, ribs, vertebrae, and heads.

318.6

A. The large inverted hair follicles commonly seen in pork jowls must be removed before the product leaves the establishment or is used for further processing.

B. Pork jowls intended for use in fabricated products or in rendering should be completely sliced or deeply scored from the "Meat" surface downward in sections one inch apart longitudinally and the cut surfaces observed for any unacceptable conditions. Mechanical slicing of frozen jowls in blocks does not permit satisfactory examination. However, mechanical slicing of unfrozen jowls with acceptable inspection by a competent establishment employee of each cut surface immediately after slicing is satisfactory. Facilities should be provided for cleaning and sterilizing contaminated equipment.

318.7 Meat byproducts containing large amounts of skin, such as detached bacon rinds, pork snouts, lips and ears, shall not be shipped from the official establishment unless these products are free of visible hair roots and otherwise suitable for inclusion in the manufacture of meat food products such as souse, scrapple, head cheese, etc.

However, if the packages are marked to indicate the skins, pork snouts, lips or ears are intended for rendering or gelatin manufacture, then freedom from visible hair roots will not be required.

318.8 This section outlines requirements for the boneless meat program other than pork. In this category are Boneless Beef, Veal and Mutton; Boneless Beef Chuck; Mixtures of Wholesale Boneless Cuts, Beef Trimmings, Veal Trimmings, Mutton Trimmings. The requirements do not apply to properly labeled wholesale cuts such as: Inside Round, Outside Round, Knuckles, Loin Strips, Plates, Navels, Clods, Briskets, Flanks, Tenderloins.

A. Inspection of Boneless Meats at Producing Establishments. The producing establishment shall have the following responsibilities common to all reinspection procedures:

1. Provide inspector properly equipped and lighted inspection areas, including 50 foot candles of light, rust resisting metal table, and adequate help.

2. Insure product is clean prior to boning. Establishments should designate an inspection area, located prior to cutting and boning operation, equipped with adequate artificial light, tool and hand-washing facilities. Establishments should designate a competent employee to inspect and remove foreign material from carcass and parts prior to boning.

3. Bone the meat in a manner to insure clean, wholesome product.

Of the procedures for reinspecting, one procedure to each production line will be used in each establishment. Circumstances relating to the needs and capabilities of the establishment will determine which procedure the Officer in Charge will permit.

B. "Regular Procedure" involves lotting all product, sampling and inspecting based on the total lot.

1. The establishment shall:

- a. Group product into coded lots in a manner acceptable to the Officer in Charge. Establishments may choose what size the lot may be.

- b. Maintain lots intact until inspection is completed.

- c. Recondition rejected lots, if possible, and resubmit them for reinspection. Control such lots so they are not combined with other lots.

d. Decharacterize or otherwise divert from edible channels all product that cannot be brought into compliance.

2. Inspectors shall:

a. Determine lot size in pounds, after lot is completely assembled.

b. Select applicable sampling plan. (See MI-450, (reverse) Score Sheet for Boneless Manufacturing Meats.) Basically the plan selected should agree with the lot size being examined. The inspector has the option, however, of selecting the next larger plan size if conditions warrant. Once a plan is selected, the number of sample units shown is the number to be examined.

c. Randomly select the number of production units required by the sampling plan. If there is more than one code involved, each should be proportionately represented in the sample. Production Units are those containers from which the 12-pound sample units are taken. If the number of production units in the lot is less than the number needed, select more than one sample unit from each production unit. Note Plans 5 and 10 are single plans; other plans are double (two steps). Always start with the first step of double plans.

d. Randomly select the required number of 12-pound sample units from the production units. A Sample Unit is a 12-pound portion of product taken from the production unit. It may come from chilled or thawed product, or sliced from frozen product. If lot consists of frozen product, defrost sample units in an acceptable manner. Do this under appropriate security.

e. Inspect product thoroughly.

f. Classify all defects found as critical, major, or minor and record the number of defects on Form MI-450 (See Example Copy below). See Table I, below, Guide for Classifying Defects in Boneless Manufacturing Meats Other Than Pork.

g. Total the defects. In double plans (15 through 50), if the number of critical, major or total defects found are equal to or less than each of the Ac (Acceptance) criteria for the first step, accept the lot. If the number of either critical, major or total defects equals or exceeds the Re (Rejection) criteria for step one, reject the lot. Complete inspection of all sample units even though one of the rejection levels is reached prior to this point. If any of the Ac criteria is exceeded, but does not reach any of the Re criteria for step one, the second step of the plan is performed by selecting new production units and sample units sufficient to satisfy

the sampling plan. The inspection is made and then all defects found in first and second steps are totaled, compared with Ac - Re criteria for total defects of both steps and decision made to either accept or reject the lot.

3. Reinspecting reconditioned rejected lots.

- a. Select sample plans as in the Regular Procedure, except use the next higher sampling plan than the one originally used.
- b. Inspect the sample in accordance with Regular Procedure and accept or reject the lot.

4. Reporting Requirements:

- a. Complete MI Form 450 in duplicate.
- b. Send original to Meat Inspection Records Unit, Chicago, Illinois.
- c. Retain the duplicate in the government office in the establishment where the inspection is made for 5 years.

C. Procedure for Inspecting "Common Source" Product. Boneless meat diverted to a further processing area and to a shipping area is considered as "common source" when it comes from: A single boning table or line that is split to feed both a further processing area and a shipping area, or a single point or area in which product from several boning table lines are commingled prior to being diverted to a further processing area and a shipping area.

Inspectors shall sample and inspect the product on a lot basis as outlined in the Regular Procedure, above, except:

1. Upon acceptance of a minimum of 60,000 pounds of product, or two days production (whichever is less) without a rejection, allow boned product to be further processed internally without lotting and sampling but otherwise given normal surveillance. Continue this procedure as long as a substantial proportion is being produced for shipment simultaneously and is lotted, inspected and accepted.

2. Upon rejection of a shipping lot, return to lotting all product and inspecting and sampling as in Regular Procedure, until such time as 60,000 pounds or two days production again passes without rejection.

D. Procedure for "On-Line" Inspection.

- 1. To qualify for On-Line Inspection, the establishment shall:
 - a. Have a good history of producing clean meat.
 - b. Assign competent personnel on a permanent continuing basis

to draw a 30-pound sample from each production line or common source at least once every half hour. The point at which the sample units are drawn is immediately before the product goes into a container.

c. Examine each sample unit for defects shown in Table I, below.

d. Tally the defects by class on the left side and by defect code on the right side of Form MI 450-1. (See below).

e. Enter the totals of the minor, major and critical defects in each sample unit as well as their overall total in the blocks under the appropriate sample number on the left side of MI 450-1.

f. Compare with individual sample limits of one critical or major defect and four total defects.

g. Add to previous Cumulative Sample totals and enter in the Cumulative column immediately to the right.

h. Take immediate corrective action whenever any defect limit is approached, or trends develop with certain types of defects.

i. Inform the inspector immediately should the defects exceed allowable limits. (In the case of "Modified On-Line" procedure (see below), he notifies inspector on his next visit.)

j. Send original Form MI-450-1 to Meat Inspection Records Unit, Chicago, Illinois.

k. Retain duplicate copy for 5 years in a quality control file to which the meat inspector has access.

2. The meat inspector shall:

a. Make certain that the plant quality control men are competent judges of defects.

b. Check the plant men's work often enough to make sure they are doing a proper inspection job.

c. Check enough samples of his own to insure the product conforms to the criteria. Check the carcasses for cleanliness.

d. Allow product to move freely as long as defect criteria are not exceeded. (Except in "Modified On-Line" where 150 pound reserve is maintained.)

e. After every occurrence of exceeding defect limits, enforce lotting and holding of product and perform sampling and

inspection by the Regular Procedure until 60,000 pounds are produced without rejection.

f. Retain the original and duplicate copy of Form MI-450 in the government office in the establishment where the inspection is made for 5 years. Advise the establishment to continue maintaining their quality control records on Form MI 450-1 and submittal of the original to the Meat Inspection Records Unit, Chicago, Illinois, during this penalty period.

E. "Modified On-Line" Inspection Procedure. Only for plants covered by patrol assignment.

1. To qualify, the plant must satisfy all those requirements outlined for the On-Line procedure except (j) above, plus:

- a. Maintain a minimum of 150 pounds of product ahead of shipping or grinding schedule for inspector's information.
- b. Provide inspector with a clean metal receptacle, of adequate size, capable of being locked.
- c. Retain original and copy of MI Form 450-1 in quality control files to which the meat inspector has access.

2. The inspector shall:

- a. Check the plant records to make sure that the plant quality control is functioning properly and in accordance with our new instructions.
- b. Check carcasses on hand for cleanliness.
- c. Draw enough 12-pound samples on each visit so that he will have accumulated 72 pounds by the last visit of the day. These samples shall be stored in a suitable locked container. Inspect and record defects on MI Form 450.
- d. In addition draw two 30-pound sample units during each visit, and examine them for defects.
- e. Make the establishment lot and hold product without shipping or grinding, whenever:
 - (1) They fail to meet any of their requirements specified.
 - (2) The 72 pounds of product has one or more critical or major defects, or six or more minor defects.
 - (3) Any 30-pound sample has one or more critical or major defects, or three or more minor defects.

- f. Make the establishment reclean all product on hand whenever conditions outlined above are found.
- g. Keep the plant on a lot inspection basis until one full week's production passes without a rejection.
- h. Send original MI Form 450 to MI Records Unit, Chicago, Illinois, and retain the copy.

LEFT SIDE MI FORM 450

For all Domestic and Import Inspection, complete Blocks 1,2,11,12,13,14,15,16, and 17.

For Domestic Inspections Only, complete Blocks 3,4,5,6, and 7.

For Import Inspections Only, complete Blocks 8,9, and 10.

EITHER DOMESTIC OR IMPORT INSPECTION

1. Check applicable block (i.e. ☒ Yes ☐ No) if an original inspection

2. Make numerical entries for date (i.e. "9 29 68" for September 29, 1968).

DOMESTIC INSPECTION

3. Check if other than import inspection.

4. Use only when making origin inspections or destination inspections of product from one domestic establishment.

5. Check ☒ 1 when lot inspected is at the producing establishment.

6. Check ☒ 2 when lot inspected is an incoming lot. Do not check both ☐ 1 & ☐ 2.

7. Enter number here whenever ☐ 2 is checked unless inspection is of a previously inspected and passed imported lot. Do not enter a number here when ☐ 1 is checked even if known.

FORM MI-450 (12-1-67)		U.S. DEPARTMENT OF AGRICULTURE CONSUMER AND MARKETING SERVICE MEAT INSPECTION DIVISION			
SCORE SHEET FOR BONELESS MANUFACTURING MEATS - OTHER THAN PORK					
DATE INSPECTED	MONTH	DAY	YEAR	REINSPECTION OF REJECTED LOT <input type="checkbox"/> YES <input type="checkbox"/> NO	
LOT AND SAMPLE IDENTIFICATION (Check Code 4 or 5 and complete corresponding portion)					
<input checked="" type="checkbox"/> 4 DOMESTIC					
ORIGINATING ESTABLISHMENT NUMBER	INSPECTION PERFORMED HERE <input checked="" type="checkbox"/> 1	INSPECTION PERFORMED HERE <input type="checkbox"/> 2	RECEIVING ESTABLISHMENT NUMBER		
<input checked="" type="checkbox"/> 5 IMPORTED					
FORM MI-450 SERIAL NUMBER	ESTABLISHMENT NUMBER	COUNTRY OF ORIGIN		(Code)	
CUSTOMS ENTRY NUMBER	CIRCUIT NO.	NAME OF IMPORTER			
NOTICE: COMPLETE THE FOLLOWING ON EACH REPORT:					
LOT SIZE (Pounds)	PRODUCT CODE	HORSE (Equine)			
	<input type="checkbox"/> 1 BEEF <input type="checkbox"/> 2 VEAL <input type="checkbox"/> 3 MUTTON-LAMB <input type="checkbox"/> 4 GOATS <input type="checkbox"/> 5 HORSE				
CARCASS SECTION:					
<input type="checkbox"/> 10 BRISKET <input type="checkbox"/> 19 SHANK <input type="checkbox"/> 20 PLATE <input type="checkbox"/> 21 FLANK <input type="checkbox"/> 22 CHUCK					
<input type="checkbox"/> 23 RIB LOIN <input type="checkbox"/> 40 ROUND <input type="checkbox"/> 50 MIXED OR OTHER AREAS					
SAMPLING PLAN USED (From Form MI-150-1)					
<input type="checkbox"/> 1 <input type="checkbox"/> 10 <input type="checkbox"/> 15 <input type="checkbox"/> 20 <input type="checkbox"/> 25 <input type="checkbox"/> 30					
SAMPLE IDENTIFICATION					
ACTION TAKEN BASED ON FIRST STEP (Check one) <input type="checkbox"/> 1 LOT ACCEPTED <input type="checkbox"/> 2 LOT REJECTED					
ACTION TAKEN ON SECOND STEP (If required) (Check one) <input type="checkbox"/> 3 SECOND STEP NEEDED <input type="checkbox"/> 4 LOT ACCEPTED <input type="checkbox"/> 5 LOT REJECTED					
REPORT IDENTIFICATION NUMBER					
REMARKS					
DETAILED STUDY DATA					
LINE NO.	DEFECT	DEFECT CODE	NO. OF DEFECTS		
1					
2					
3					
4					
5					
6					
INSPECTION TIME		SAMPLING	MINOR	MAJOR	CRITICAL
HOURS MINUTES		FIRST STEP			
INSPECTED BY (Signature of Inspector)		SECOND STEP			
		GRAND TOTAL			

LEFT SIDE MI FORM 450

IMPORT INSPECTION

8. Check here for all imported lots at port of entry or at destination inland. Do not check if lot is an incoming imported lot already inspected and passed.

9. Enter exactly as it appears on container.

10. Use new 3 digit country codes Section 327.36 of the Manual.

EITHER DOMESTIC OR IMPORT INSPECTION

11. Indicate which major area of carcass is the source of the boneless meat trimmings. If source is several, other or unidentifiable area, check ☒ 50.

12. Sampling plans are on reverse side.

13. For internal use within circuit.

14. Enter any number from 1 to 99. Do not use the same number twice in one day in one circuit.

15. Enter time spent on inspection of lot including sampling; estimated if not continuous.

16. For use as instructed by PMID in recording occurrences of certain defects in future special studies.

17. Enter totals of defects recorded on right side of form.

FORM MI-450 (12-1-67)		U.S. DEPARTMENT OF AGRICULTURE CONSUMER AND MARKETING SERVICE MEAT INSPECTION DIVISION				
SCORE SHEET FOR BONELESS MANUFACTURING MEATS - OTHER THAN PORK						
DATE INSPECTED →	MONTH	DAY	YEAR	REINSPECTION OF REJECTED LOT <input type="checkbox"/> YES <input type="checkbox"/> NO		
LOT AND SAMPLE IDENTIFICATION (Check Code 4 or 5 and complete corresponding portion)						
<input type="checkbox"/> 4 DOMESTIC						
ORIGINATING ESTABLISHMENT NUMBER	INSPECTION PERFORMED HERE <input type="checkbox"/> 1	INSPECTION PERFORMED HERE <input type="checkbox"/> 2	RECEIVING ESTABLISHMENT NUMBER			
<input type="checkbox"/> 5 IMPORTED						
FORM MI-410 SERIAL NUMBER	ESTABLISHMENT NUMBER	COUNTRY OF ORIGIN (Code)				
CUSTOMS ENTRY NUMBER	CIRCUIT NO.	NAME OF IMPORTER				
NOTICE: COMPLETE THE FOLLOWING ON EACH REPORT.						
LOT SIZE (Pounds)	PRODUCT CODE <input type="checkbox"/> 1 BEEF <input type="checkbox"/> 2 VEAL <input type="checkbox"/> 3 LAMB <input type="checkbox"/> 4 MUTTON <input type="checkbox"/> 5 GOATS <input type="checkbox"/> 6 HORSE (If spotted)					
CARCASS SECTION <input type="checkbox"/> 10 BRISKET <input type="checkbox"/> 11 SHANK <input type="checkbox"/> 12 PLATE <input type="checkbox"/> 13 FLANK <input type="checkbox"/> 14 CHUCK <input type="checkbox"/> 15 RIB LOIN <input type="checkbox"/> 16 ROUND <input type="checkbox"/> 17 MIXED OR OTHER AREAS						
SAMPLING PLAN USED (From Form MI-450-1) <input type="checkbox"/> 18 <input type="checkbox"/> 19 <input type="checkbox"/> 20 <input type="checkbox"/> 21 <input type="checkbox"/> 22 <input type="checkbox"/> 23 <input type="checkbox"/> 24 <input type="checkbox"/> 25						
SAMPLE IDENTIFICATION			ACTION TAKEN BASED ON FIRST STEP (Check one) <input type="checkbox"/> 1 LOT ACCEPTED <input type="checkbox"/> 2 LOT REJECTED <input type="checkbox"/> 3 SECOND STEP NEEDED			
REPORT IDENTIFICATION NUMBER			ACTION TAKEN ON SECOND STEP (If required) (Check one) <input type="checkbox"/> 4 LOT ACCEPTED <input type="checkbox"/> 5 LOT REJECTED			
REMARKS			DETAILED STUDY DATA			
			LINE NO.	DEFECT	DEFECT CODE	NO. OF DEFECTS
			1			
			2			
			3			
			4			
			5			
			6			
INSPECTION TIME			SAMPLING MINOR MAJOR CRITICAL TOTAL			
HOURS			FIRST STEP			
MINUTES			SECOND STEP			
INSPECTED BY (Signature of Inspector)			GRAND TOTAL			

RIGHT SIDE MI FORM 450

TYPE OF DEFECT AND CLASSIFICATION (See Instructions)	DEFECT CODE	NO. OF DEFECTS FOUND					
		1ST STEP			2ND STEP		
		=	M	C	=	M	C
BLOOD CLOTS, BRUISES	100						
	101						
	102						
BONE FRAGMENTS	150						
	151						
	152						
DETACHED CARTILAGE, LIGAMENTS	200						
	201						
	202						
FECAL MATERIAL, INGESTA	251						
	252						
HARMFUL EXTRANEEOUS MATERIAL (Glass, Metal, Wood, Plastic, etc.)	301						
	302						
HARMLESS EXTRANEEOUS MATERIAL (Paper, soil dust, insects, etc.)	350						
	351						
	352						
HAIR, WOOL OR HIDE	400						
	401						
	402						
OFF CONDITION	452						
PATHOLOGICAL LESIONS	501						
	502						
STAINS, DISCOLORED AREAS	600						
	601						
	602						
OTHER (Specify)	800						
	801						
	802						

Detailed explanation of each Defect Code in Section 318.8 (Table 1) of the Manual.

Tally individual defects as found in each 12 pound sample unit to left of applicable Defect Code. Keep tallies for 1st and 2nd steps separate.

Enter the respective totals for each step of each Defect Code in the applicable unshaded block. WRITE NUMBERS CLEARLY. Do not write 0's for no defects.

LEFT SIDE MI FORM 450-1

1. Number of pounds boned during the indicated shift, on the indicated line or table, and of the indicated product and carcass section.

2. Product Code and Carcass Section Code obtained from Form MI 450.

3. Make numerical entries for date (i.e. "9 29 68" for September 29, 1968).

4. Enter a number from 1 to 9 identifying the particular inspection or boning line or table from which samples are drawn.

5. Enter a number from 1 to 3 identifying the particular shift during the day.

6. Enter time spent by meat inspector in verification sampling, inspection and overseeing quality control procedures.

FORM MI-450-1 (11-1-68)

ON-LINE INSPECTION OF BONELESS MANUFACTURING MEATS
OTHER THAN PORK

INSTRUCTIONS: Below, add individual sample totals to previous cumulative totals, record in cumulative column, and compare with limits. No single 30 lb. sample may have more than 1 critical or major defect or more than 4 total defects. If sample or cumulative limits are exceeded, examine subsequent production on a lot basis until 60,000 consecutive lbs. pass.

CODE	DATE	MONTH	DAY	YEAR	ESTABLISHMENT NO.	NAME OF PRODUCT	ICODE		
CARCASS SECTION (Code)	1	2	3	4	5	6	7		
CLASSES OF DEFECTS	IN SAMPLE NO. 1	CUMULATIVE SAMPLES	LIMIT	IN SAMPLE NO. 2	CUMULATIVE SAMPLES	LIMIT	IN SAMPLE NO. 3	CUMULATIVE SAMPLES	LIMIT
MINOR	100 LB.		2		100 LB.	4		100 LB.	9
MAJOR			0*			0*			0*
CRITICAL			0†			0†			0†
TOTAL			2			4			9
MINOR	NO. 2 (100 LB.)		7	NO. 3 (100 LB.)		9	NO. 4 (100 LB.)		18
MAJOR			1			1			1
CRITICAL			0†			0†			0†
TOTAL			7			9			19
MINOR	NO. 5 (100 LB.)		11	NO. 6 (100 LB.)		13	NO. 7 (100 LB.)		24
MAJOR			1			2			2
CRITICAL			0†			0†			0†
TOTAL			11			13			26
MINOR	NO. 10 (100 LB.)		18	NO. 11 (100 LB.)		16	NO. 12 (100 LB.)		34
MAJOR			2			2			4
CRITICAL			0†			0†			0†
TOTAL			19			16			38
MINOR	NO. 13 (100 LB.)		18	NO. 14 (100 LB.)		20	NO. 15 (100 LB.)		58
MAJOR			2			2			6
CRITICAL			0†			0†			0†
TOTAL			19			20			64
MINOR	NO. 16 (100 LB.)		22	NO. 17 (100 LB.)		24	NO. 18 (100 LB.)		88
MAJOR			2			2			8
CRITICAL			0†			0†			0†
TOTAL			22			24			96
MINOR	NO. 19 (100 LB.)		26	NO. 20 (100 LB.)		27	NO. 21 (100 LB.)		123
MAJOR			2			4			12
CRITICAL			0†			0†			0†
TOTAL			28			27			135
SIGNATURE, QUALITY CONTROL INSPECTOR				SIGNATURE, MEAT INSPECTOR				SUPERVISION TIME (Government Inspector)	
								HRS. MIN.	

* One is allowable if none in previous 3 samples from same production line.
† One is allowable if none in previous 20 samples from same production line.

LEFT SIDE MI FORM 450-1

7. The number of minor, major, and critical defects are tallied here and tallied by defect on the right side of MI Form 450-1 for Sample Number 1. Total defects are entered on line 4.

8. The number of minor, major, and critical defects are tallied here and tallied by defect on the right side of MI Form 450-1 for Sample Number 2. Total defects are entered on line 4.

9. The cumulative numbers of minor, major, and critical defects entered for Sample Numbers 1 & 2 are entered here and totaled. At end of each sample, totals should be balanced with respective tallies under defects on right side of MI 450-1.

10. The numbers of minor, major and critical defects are tallied here and tallied by defect on the right side of MI Form 450-1 for Sample Number 13. Total defects are entered on line 4.

FORM MI-450-1 (11-1-68)										USDA-CRMS MEAT INSPECTION	
ON-LINE INSPECTION OF BONELESS MANUFACTURING MEATS OTHER THAN PORK											
INSTRUCTIONS: Below, add individual sample totals to previous cumulative totals, record in cumulative column, and compare with limits. No single 30 lb sample may have more than 1 critical or major defect or more than 4 total defects. If sample or cumulative limits are exceeded, examine subsequent production on a lot basis until 60,000 consecutive lbs. pass.											
CODE 13	DATE INSPECTED	MONTH	DAY	YEAR	ESTABLISHMENT NO.	NAME OF PRODUCT			CODE		
CARCASS SECTION (Code)	LINE NO.	SHIFT	TOTAL NO OF SAMPLES INSPECTED			PRODUCTION PER SHIFT (Pounds)					
CLASSES OF DEFECTS	IN SAMPLE NO. 1 (30 LB.)	CUMULATIVE SAMPLES	LIMIT	IN SAMPLE NO. 2	CUMULATIVE SAMPLES	LIMIT	IN SAMPLE NO. 3	CUMULATIVE SAMPLES	LIMIT	IN SAMPLE NO. 4	CUMULATIVE SAMPLES
MINOR			3			4					
MAJOR			0*			0*					
CRITICAL			0†			0†					
TOTAL			2			4					
MINOR	NO. 4 (30 LB.)			NO. 5 (30 LB.)			NO. 6 (30 LB.)			NO. 7 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
MINOR	NO. 8 (30 LB.)			NO. 9 (30 LB.)			NO. 10 (30 LB.)			NO. 11 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
MINOR	NO. 12 (30 LB.)			NO. 13 (30 LB.)			NO. 14 (30 LB.)			NO. 15 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
MINOR	NO. 16 (30 LB.)			NO. 17 (30 LB.)			NO. 18 (30 LB.)			NO. 19 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
MINOR	NO. 20 (30 LB.)			NO. 21 (30 LB.)			NO. 22 (30 LB.)			NO. 23 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
MINOR	NO. 24 (30 LB.)			NO. 25 (30 LB.)			NO. 26 (30 LB.)			NO. 27 (30 LB.)	
MAJOR											
CRITICAL											
TOTAL											
SIGNATURE, QUALITY CONTROL INSPECTOR						SIGNATURE MEAT INSPECTOR			SUPERVISION TIME (By Government Inspector)		
									HRS. MINUTES		

* One is allowable if none in previous 3 samples from same production line.
† Two is allowable if none in previous 20 samples from same production line.

11. The cumulative numbers of minor, major and critical defects entered following Sample Number 12 plus the numbers for Sample Number 13 are entered here and totaled. If any exceed the adjacent "Limit" numbers, the meat inspector must enforce holding and lotting of product. This action must also be taken on the occurrence of more than 1 critical or major defect, or 4 total defects in one sample. At end of each sample totals should be balanced with respective tallies under defects on right side of MI-450-1.

RIGHT SIDE MI FORM 450-1

TYPE OF DEFECT AND CLASSIFICATION <small>For each shift, enter defect counts in appropriate blocks at right.</small>	DEFECT CODE	NO. OF DEFECTS FOUND		
		MINOR	MAJOR	CRITICAL
BLOOD CLOTS, BRUISES	100			
	101			
	102			
BONE FRAGMENTS	150			
	151			
	152			
DETACHED CARTILAGE, LIGAMENTS	200			
	201			
	202			
PERIARTICULAR MATERIAL, INDETERMINATE	251			
	252			
HARMFUL EXTRANEEOUS MATERIAL (Glass, Metal, Wood, Plastic, etc.)	301			
	302			
HARMLESS EXTRANEEOUS MATERIAL (Paper, soil dust, insects, etc.)	350			
	351			
	352			
HAIR, WOOL ON HIDE	400			
	401			
	402			
OPP CONDITION	452			
PATHOLOGICAL LESIONS	501			
	502			
STAINS, DISCOLORED AREAS	600			
	601			
	602			
OTHER (Specify)	800			
	801			
	802			

Original to Meat Inspection Program Records Unit, Chicago, Illinois

Detailed explanation of each Defect Code in Section 318.8 (Table 1) of Manual.

Tally individual defects found in each 30 pound sample unit to the left of the applicable Defect Code.

Enter total for the shift of each Defect Code in the applicable unshaded block. WRITE NUMBERS CLEARLY. Do not enter 0's for no defects. Total of minor, major and critical defects must equal the respective totals in last sample entry on the left side of MI Form 450-1.

TABLE I

Defects Description	Defect Code	Defect Class
<u>Blood Clots</u> - 1½" to 6" in greatest dimension.	100	Minor
<u>Blood Clots</u> - More than 6" in greatest dimension, or numerous (over 5) minor blood clots in one sample unit (do not score as minor defects also) that do not seriously affect the usability of the product.	101	MAJOR
<u>Blood Clots</u> - One or more occurring in such number or size as to seriously affect the usability of the product.	102	Critical
<u>Bruises</u> - More than 2½" in greatest diameter <u>and</u> less than 1" deep.	100	Minor
<u>Bruises</u> - More than 2½" in greatest diameter <u>or</u> more than 1" deep, or numerous (over 5) minor bruises in one sample unit (do not score as minor defects also) that do not seriously affect the usability of the product.	101	MAJOR
<u>Bruises</u> - One or more occurring in such number or size as to seriously affect the usability of the product.	102	Critical
<u>Bone Fragments</u> - Less than 1½" in greatest dimension.	150	Minor
<u>Bone Slivers (from rib)</u> - Less than 3" long and less than ¼" in greatest diameter and flexible, or a cartilage or bone chip from a rib end more than ¾" in greatest dimension that is thin and crumbles easily, and that may or may not have attached muscle tissue.	150	Minor
<u>Bone Fragments</u> - 1½" or more in greatest dimension, or numerous (over 5) minor fragments in one sample unit (do not score as minor defects also) that do not seriously affect the usability of the product.	151	MAJOR
<u>Bone Fragments</u> - One or more occurring in such number or size as to seriously affect the usability of the product.	152	Critical
<u>Detached Cartilage, Ligaments</u> - 1" or more long and free of muscle tissue. (Also see Bone Slivers (from rib) Code 150).	200	Minor
<u>Detached Cartilage, Ligaments</u> - Numerous (over 5) minor defects in one sample unit (do not score as		

Defects Description	Defect Code	Defect Class
minor defects also) that do not seriously affect the usability of the product.	201	MAJOR
<u>Detached Cartilage, Ligaments</u> - Defects occurring in such number as to seriously affect the usability of the product.	202	Critical
<u>Ingesta</u> - Covering an area $\frac{1}{2}$ " or less in greatest dimension.	251	MAJOR
<u>Ingesta</u> - Covering an area more than $\frac{1}{2}$ " in greatest dimension.	252	Critical
<u>Fecal Material</u> - Any amount.	252	Critical
<u>Harmful Extraneous Material</u> - Any organic or inorganic substance that could singly or in aggregate cause minor bodily irritation or discomfort (e.g. chemicals that may cause mild reaction, hard objects that are not likely to cut or bruise, etc.).	301	MAJOR
<u>Harmful Extraneous Material</u> - Any organic or inorganic substance that could singly or in aggregate cause injury or illness (e.g. poisonous or toxic chemicals, sharp pieces of metal, glass, hard plastic, etc.).	302	Critical
<u>Harmless Extraneous Material</u> - Paper or plastic wrap 7 sq. in. or less, specks of rail dust or similar material covering area between $\frac{1}{8}$ " to $\frac{1}{2}$ " in greatest diameter, single wild oats and other grass beards not associated with inflammatory conditions.	350	Minor
<u>Harmless Extraneous Material</u> - Such as blunt piece of wood 1" or more long, paper or plastic over 7 sq. in., specks of rail dust or similar material covering an area with a greatest diameter exceeding $\frac{1}{2}$ " and small insects not associated with insanitation. Numerous (over 5) minor defects in a sample unit that do not seriously affect the usability of the product.	351	MAJOR

Defects Description	Defect Code	Defect Class
<u>Harmless Extraneous Material</u> - Large insects and insects associated with insanitation or any other material that occurs in such number or size as to seriously affect the usability of the product.	352	Critical
<u>Hair, Wool or Hide</u> - Hide with or without attached wool less than $\frac{1}{2}$ " in greatest diameter, 5 single strands of hair (total number hair divided by 5 = number defects), 1 cluster of hair.	400	Minor
<u>Hair, Wool or Hide</u> - Hide with or without attached wool $\frac{1}{2}$ " or more in greatest diameter, numerous (over 25) single strands of hair in one sample unit (do not score as minor also), numerous (over 5) clusters of hair in one sample unit, (do not score as minor also), provided none of the above seriously affects the usability of the product.	401	MAJOR
<u>Hair, Wool or Hide</u> - Hair, wool or hide that occurs in such amount as to seriously affect the usability of the product.	402	Critical
<u>Off Condition</u>	452	Critical
<u>Pathological Lesions</u> - May be classified as major defects when they individually or in aggregate do not seriously affect, or are likely to seriously affect the usability of the product for its intended purpose. Examples of this are singly occurring deep seated encapsulated abscesses or parasitic cysts in frozen meat and such conditions as tissue degenerations and scar tissue. All proposals to downgrade pathological lesions from critical to major defects are to be referred to PMID for decision.	501	MAJOR
<u>Pathological Lesions</u> - Any lesion unless excepted as noted under Code 501.	502	Critical
<u>Stains, Discolored Areas</u> - Covering an area $\frac{1}{2}$ " to $1\frac{1}{2}$ " in greatest diameter.	600	Minor
<u>Stains, Discolored Areas</u> - Covering an area more than $1\frac{1}{2}$ " in greatest diameter, or numerous (over 5) minor stains in one sample unit, (do not score as minor defects also) that do not seriously affect the usability of the product.	601	MAJOR

Defects Description	Defect Code	Defect Class
<u>Stains, Discolored Areas</u> - Minor or major areas occurring in such number as to seriously affect the usability of the product.	602	Critical
<u>Other</u> - A defect that individually or in aggregate affects the appearance of the product but is not likely to affect its usability.	800	Minor
<u>Other</u> - A defect that individually or in aggregate materially affects the usability of the product.	801	MAJOR
<u>Other</u> - A defect that individually or in aggregate seriously affects the appearance or usability of the product.	802	Critical

F. Sealing Containers. That part of the Regulations, Section 325.6 that requires 25 percent or more of the contents of a car to be unmarked before sealing is permitted would not apply to the sealing of boneless manufacturing meats for compliance with this section.

1. Application of wing seals to shipping containers. In official establishments a number of sealed containers may be selected at random to determine if wing seals are properly applied.

a. Fiberboard containers. Containers of this type may be wrapped lengthwise or girthwise with filament tape and the wing seal applied at the point where the two ends of the tape overlap. The ends of the tape should overlap at the end of the container.

b. Barrels. Slack barrels and metal barrels of boneless meats may be sealed provided the boneless meat is in a close polyethylene film liner. After filling the container, the polyethylene film is "bunched" at the top. A heavy cord or filament tape shall be threaded through the "bunched" point and wrapped around the neck of the bag and tied or overlapped at the ends. The knot of the tie or the two overlapped ends shall be enclosed in the wing seal.

c. The inspector shall maintain security of wing seals as follows:

(1) Maintain records, suitable to the District Director, of receipt of shipments of seals.

(2) Be assured that wing seals and truck seals on hand in the establishment are under adequate security at all times.

(3) Maintain an inventory record, suitable to the District Director, of the wing seals used. This would include the identification of lots on which seals were applied.

2. Sealing vehicles containing boneless manufacturing meat destined for approved warehouses.

a. Company seal shall be used. Application of the seal to the vehicle shall be under supervision of the inspector. The inspector will modify Form MI-408 to show the company seal number.

b. Company shall provide a weather resistant warning tag, with black ink, with the following statement, "This seal shall be broken only by a designated employee of the warehouse as approved by the Processed Meat Inspection Division of the U. S. Department of Agriculture."

- c. The inspector will distribute Form MI-408 as follows:
- (1) Original to the Officer in Charge in the Circuit at the receiving warehouse.
 - (2) Copy marked "inside sealed car" shall be so placed.
 - (3) Copy marked "origin station" to the Officer in Charge of the Circuit in which the producing establishment is located.
 - (4) Copy marked "origin establishment" retained at origin establishment.

3. Sealing vehicles containing boneless meats destined for official establishments.

- a. Government seal and warning tags will be used.
- b. MI-408 will be used and distributed as directed on the form.

4. Shipments of boneless meats in a sealed vehicle, designated to be unloaded at more than one receiving location, will be accompanied by one Form MI-408 or one Approved Warehouse Certificate of Outgoing Shipments, whichever is appropriate. The establishment or warehouse where the first product is unloaded will, for record purposes, receive the entire shipment. A new Form MI-408 or Warehouse Certificate will be issued to accompany the product to be transshipped and will bear the following statement, "This form covers the transshipped portion of a split shipment. Copy of Form MI-408 (or Warehouse Certificate) received with shipment is on file." The inspector or warehouseman will attach a copy of this form to the one he received covering the shipment and place both forms in the appropriate file. This procedure will be repeated until the remaining portions of the shipment have reached their ultimate destinations.

G. Control of Product Entering Federal Inspected Establishments.
These instructions will not apply to product entering official establishments for temporary storage for later distribution in the original container.

Inspectors must be alert to recognize, interpret and properly handle product offered for entry into official establishments which might not, in fact, be federally inspected product. Official establishments using fiberboard containers for boneless meats should use the printed inspection legend. The domestic meat label on containers of product entering should be checked closely. Product entering in blood soaked; broken and mutilated containers showing an unusual amount of damage should be considered suspicious. Bruised, blackened or excessively bloody meat may be an indication that the meat was derived from animals which died other than by slaughter. Close surveillance for mislabeling with reference to species of origin should be made. If product shows packing or conditions which are inconsistent with federally inspected product, this should serve as cause for alarm and further checking.

Section 318.8(C)

When illegitimate shipments are suspected, they should be immediately reported to the Officer in Charge who shall promptly contact the appropriate officer of the Compliance and Evaluation Staff. All product should be retained. No preliminary examination or determination of product entering should be made until all product is unloaded into the official establishment. Pertinent information such as description of truck, truck company name, license numbers, etc., should be noted.

1. Sealed Product Entering.

a. Product entering may be sealed with wing seals, government seal of carrier, or ID warehouse seal. When received plants shall:

- (1) Immediately notify inspector. Wing sealed shipments arriving in absence of inspector may enter provided control of the product is maintained until inspector arrives.
- (2) Supply inspector with name of product, quantity, type container, origin establishment, ID warehouse, broker, etc.
- (3) Apply some mark of acceptance or identification to each unit upon inspector authorization.

b. Inspector's Procedure.

- (1) Removes all seals if arrival is by sealed carrier.
- (2) If no suspicion of substitution exists, examine at least two units for condition only. If conditions found warrant, defrost partially or wholly and examine additional units; or resort to procedure outlined in Conventional Procedure for inspecting boneless meats. If suspicion of substitution exist, retain product and obtain additional information. If satisfactory explanation is received, proceed as in Conventional Procedure.
- (3) Supervise application of acceptance or identify marks.
- (4) Make disposition of documents accompanying shipments.

2. Unsealed Product Entering.

a. Establishment shall satisfy same requirements as for sealed product.

b. The inspector shall:

- (1) Proceed with Conventional Inspection Procedure.

Laboratory sampling for specie identification on systematic basis will be directed. District Directors will notify Officers in Charge when their Circuit is to sample. When so notified, submit ten samples from the Circuit c/o Microbiology Laboratory in Beltsville, Maryland. The following priority should be followed in selecting samples: (1) unsealed lots of domestic and imported boneless meats; (2) shipments of domestic and imported boneless meats from approved ID warehouses; (3) shipments of domestic and imported boneless meats coming in under government seal. Samples should be submitted within one week after notification.

Shipments of boneless meats which arouse suspicion because of the character of the product, condition of container, or lack of proper identification should be sampled for specie determination at all times. Samples of ground meats may be submitted if there is suspicion that they were prepared at unusual hours of operation.

318.9 Criteria for Approved Warehouse. A warehouse will be approved for receiving, storing and shipping boneless manufacturing beef, veal and mutton if it is a public refrigerated warehouse and the operator thereof applies, qualifies, and agrees to pay for Identification Service under the regulations in 9 CFR Part 340. The service shall consist of such supervisory inspection of premises, inventory, records and operations of the approved warehouse as is deemed necessary by the Processed Meat Inspection Division. Fees and charges shall cover only the cost of such supervisory service.

The foregoing will also apply to the receiving, handling, storage and shipping of animal byproducts, shipped with MI Form 508, intended for manufacture of certified dog and other animal food.

A. Facilities. Identification Service will not be furnished at any warehouse if the facilities or operating practices are such that the articles handled thereat may become unsanitary, unwholesome, or otherwise unfit for human food, or improperly marked or labeled.

B. Control and Identification of Lots. As a condition of approval, the warehouse operator must comply with the following:

1. Allow seals on incoming shipments of boneless meats to be broken only by designated employee. Warehouse operators must designate one or more employees, acceptable to the Officer in Charge, to break seals and sign shipping documents. Breaking seals shall be limited only to company or approved warehouse seals on incoming shipments of boneless beef, veal or mutton in containers marked "U. S. Inspected and Passed," and which are for storage under Identification Service.

2. Stamp or otherwise identify each lot of such boneless beef, veal or mutton received. The shipment must be accompanied by Form MI-408 or proper warehouse certificate in the form outlined in Paragraph D.

Stamp or otherwise identify each lot of properly marked and decharacterized containers of hog lungs or other meat and animal byproducts received under company seal from a federally inspected establishment. Each shipment must be accompanied by Form MI-508 from the official establishment of origin.

3. Segregate by lot number and location federally inspected meat and meat food products from other articles in the warehouse in such a manner as to prevent inadvertent substitution of other meat products. This control is based on the understanding that product will remain intact. If containers from a lot are opened for examination, it must be done under Identification Service to maintain identity as a sealed lot.

4. Maintain records for each lot of boneless meats shipped from the approved warehouse to an official establishment or another approved warehouse.

C. Records and Certification of Incoming Shipments. With respect to the receipt of certified boneless meat at an approved warehouse, the following record will be maintained for each lot:

1. Date of arrival.

2. Carrier.

3. Shipper and his official establishment or ID number, or approved warehouse ID number; for imported meat, name of shipper or importer.

4. Warehouse customer record for whom the meat is stored.

5. Stated description of meat.

6. Quantity in the lot.

7. Warehouse lot number.

8. Inbound company or approved warehouse seal number, and the seal itself.

D. Records and Certification of Outgoing Shipments. With respect to the shipment of boneless meat and animal byproducts for certified dog or other animal food from the approved warehouse to the official establishment, or certified dog food plant, the following record will be maintained for each lot:

To: United States Department of Agriculture Consumer and Marketing Service Processed Meat Inspection Division		1. Date	2. Certificate No.
This is to certify that the meat or meat byproducts described herein are of a lot or lots received from an official establishment or other official source described herein under unbroken seal, and the identity of such lots has been maintained, and the meat products described herein have not been deboned or otherwise prepared or repackaged or relabeled while in the custody of this approved public warehouse.			
3. Consignee		9. Name and No. of official source from which product originated	
4. Description of Product		10. Name of Carrier	
5. Numbers and Types of Containers		11. Approved Warehouse Seal No.	
6. Total Weight		12. Name and No. of Approved Warehouse	
7. Warehouse Lot(s) or Number(s)		13. Date of Shipment	
8. Other Marks of Identification (Include pertinent identification marks and import code numbers, if any.)		14. Title and Signature of Designated Employee	

Section 318.9(D)

Only the designated warehouse employee signs the certificate. This certificate should be printed by the warehouse and completed in triplicate. Two copies are to accompany the shipment and one copy will remain with the files. The receiving inspector will return one copy to the Officer in Charge of the Circuit having the responsibility for surveying the approved warehouse from which product originated. This returned copy will be used by that responsible Circuit to maintain constant familiarity with shipments certified from the approved warehouse and as a check against the records required to be kept by the approved warehouse.

Approved warehouse seals covering shipments of boneless meats or meat byproducts for certified dog food are to be broken only under the supervision of a Meat Inspection employee when used to certify product entering an official establishment or a certified dog food establishment. So as to preclude house employees from inadvertently breaking these seals, the approved warehouse may print warning tags to be attached to seals.

E. Penalties. Willful false entries in the warehouse records or willful false statements in the certificates and similar offenses are felonies subject to the penalties of 18 U. S. Code 1001. Criminal penalties are also provided for in the Agricultural Marketing Act (7 U.S.C. 1622(h)) and the Meat Inspection Act (21 U.S.C. 78, 79, 87, 88, 91) for specified offenses, including certain false representation and unauthorized use of official marks or other identification devices.

F. Withdrawal of Service. Approval of the warehouse may be canceled whenever the Administrator or his delegate determines, after opportunity is afforded to the warehouse operator to present his views, that reliance cannot be placed on the records or certificates of the warehouse operator or his employees or that such operator or any of his employees or agents acting within the scope of the employment or agency has failed to comply with any of the conditions of approval or has violated the Meat Inspection Act (21 U.S.C. 71 et seq) or Section 203(h) of the Agricultural Marketing Act (7 U.S.C. 1622(h)) or any of the regulations promulgated thereunder. Pending final determination, such approval may be suspended summarily in accordance with Section 9 of the Administrative Procedure Act (5 U.S.C. 1008).

318.10 Ice glazing of frozen meat products, which usually consists of treating pork cuts by dipping in water or spraying them with water after they are frozen in a manner which will build up a coating of ice on the surface of the product, is a long-standing practice which has been conducted at storage freezers throughout the country. The procedure is not considered to be a processing operation and is, therefore, not required to be performed in official establishments.

Ice glazed product may be received into official establishments if it can be identified as inspected and passed. When received as inspected product, careful inspection should be made to determine if any soiling or other unsatisfactory condition is present, and proper reconditioning must be required before other handling is permitted. Generally, reconditioning can be satisfactorily accomplished by washing the outer surface under a spray until the ice disappears.

318.11 Preparation - General

A. Establishments are responsible for preparing all products in compliance with applicable regulations. Whatever controls are necessary to obtain such compliance must be placed over the manufacturing processes. The following control measures have been found effective:

1. Use a specific tested formula for each product and require strict adherence to the formula. If it is necessary to deviate from a formula which is known to produce a product in compliance with the Regulations, the establishment should expect to carefully work out such deviation with the inspector before regular production is started.

2. Require accurate measurement and positive identification of all ingredients going into the manufactured product.

3. Use specific tested cooking and smoking practices that are known to produce a product in compliance with the Regulations.

4. Provide positive identification of product through the manufacturing processes and assure correct marking, labeling, or both, with approved materials.

5. Frequently check the weight of the finished product against total amount of ingredients used.

6. Provide responsible supervision in the processing department to see that the controls are effective at all times.

B. Water holding capacity of product during smoking and cooking may be affected by one or more of the following: Use of high speed emulsifying grinders, longer chopping times in improved sausage fabricating equipment, inclusion of pork skin (unskinned pork jowls), or the use of dry ice in chopping operations.

1. When an establishment adopts these or other new methods of manufacturing cooked sausage, such as frankfurters or bologna, the inspector should undertake frequent samplings for laboratory analysis. Sampling should be continued until a standardized method of preparation has been established which will produce a sausage that does not contain excessive added water.

2. After an acceptable standard method of manufacture has been established, occasional check samples should serve to point up any needed adjustments. Naturally, when the method of preparation is changed or when significant formulation changes are made or whenever there is any reason for the inspector to suspect that the finished product is in violation of the Regulations, samples should be taken frequently to assure that only product which is in compliance with the Regulations is distributed.

C. The inspector has the responsibility of determining that all products prepared under his supervision comply with applicable regulations. To accomplish this effectively he must:

1. Have a thorough knowledge of the formulas and manufacturing processes used in preparing each product. To obtain this information, the inspector will observe the formulation of the product and manufacturing processes sufficiently to become thoroughly familiar with the practices used by the establishment.

2. Require such controls by the establishment as will result in all product manufactured being in compliance with applicable regulations concerning composition and correct marking and labeling.

3. Be certain that all products within the area of assignment is prepared with appropriate formulas and by methods that will result in compliance with the Regulations.

4. Know that all ingredients used in the preparation of products are wholesome and acceptable.

5. Permit the distribution of product that is in compliance with the Regulations and retain any product that is not. This action must be based on actual knowledge of the preparation of the product. Samples of such products shall, of course, be taken for laboratory analysis, if such analysis is deemed necessary.

6. Require changes in formula when necessary to yield a product in compliance with the Regulations.

7. Collect such samples for laboratory analysis as are necessary to determine whether changes in manufacturing practices are needed to assure compliance with the Regulations.

D. The Supervisor has the usual responsibility to determine that the inspector working under his supervision performs effectively in the area of his assignment. To accomplish this the supervisor should:

1. Understand thoroughly the controls used by the management of the establishment to assure that all product manufactured is in compliance with the Regulations.

2. Understand thoroughly the inspection supervision given to the manufacturing processes by the inspector.

3. Collect check samples for laboratory analysis at irregular intervals to determine the effectiveness of the control program used by the establishment and the supervision given by the inspector.

E. The responsibilities of the establishment, the meat inspector, and the supervisor are clearly outlined in the foregoing paragraphs. Any inspector or supervisor who fails to fully assume his responsibilities or fails to require the establishment to prepare products in compliance with the Regulations will be considered for such action as deemed necessary to obtain full enforcement of the Meat Inspection Regulations.

318.12 Favorable decision by the Technical Services Division with respect to any new article or material offered for use at an inspected establishment does not relieve the local inspector of his responsibility to see that it is suitable for the purpose intended and is properly used.

The manufacture of equipment, or the distributor of such materials as detergents, insecticides, rodenticides, plastics, lacquers, and the large variety of probable ingredients of meat food products, usually desires to have the Officer in Charge and the Technical Service Division determine the suitability of the particular article for use under Federal meat inspection. In fact, it is necessary that the Technical Services Division review proposals to use such new articles and materials so as to maintain a high degree of uniformity in applying our requirements throughout the meat packing industry. In reviewing these proposals, the Technical Services Division determines their suitability under existing regulations and requirements and endeavors to ascertain whether their use by an inspected establishment will or will not create an objectionable condition. Frequently, arrangements are made for a trial before final decision is made.

Even though the Technical Services Division makes every effort to determine the suitability of a new product, a favorable decision does not constitute blanket endorsement. Final determination with respect to its use in any particular plant is the responsibility of the local inspector. The decision by the Technical Services Division that any article or material is generally suitable for use under Federal meat inspection constitutes assurance to the inspector that its use should be permitted so long as there is no local condition that would indicate otherwise. It is the inspector's responsibility to make this local determination and to inform the Technical Services Division of adverse findings.

318.13

A. Hardwood or hardwood sawdust alone or in combination with redwood or redwood sawdust is acceptable for smoking. The resinous woods are unacceptable for smoking. Redwood is not a resinous wood.

B. The use of steam in smokehouses is permitted, but a combination of steam and smoke is not. The amount of steam should not be so great that its use will result in excess condensation and consequent dripping.

Section 318.14

318.14 Crushed or ground bone as such is not to be used as an ingredient of a meat food product. This does not preclude the use of bone in the manufacture of soup stock which is intended as an ingredient of a meat food product. The bone-crushing operation may be conducted in the edible products department provided that the handling of the bones and their preparation do not create an unsanitary condition or in any way interfere with inspection or preparation of meat food products, and that only clean sound bones derived from U. S. Inspected and Passed carcasses are used.

318.15

A. Cured, unsmoked, boneless pork shoulders or pork shoulder butts in casings or similar wrappings in consumer-size packages do not have characteristics associated with pork products which would be eaten without further cooking; accordingly, treatment of such product to destroy possible live trichinae shall not be required in official establishments.

B. Cured products of this kind in consumer-size packages shall not contain more than 10 percent added moisture as a result of the curing process.

318.16 The inspector is responsible to assure himself that all nonmeat products being used in the official establishment have been found acceptable. A part of his control includes examining the material before acceptance.

All materials such as curing mixtures, seasonings, spices, tomato puree, cereals, nonfat dry milk, and the like, shall be labeled to show the name of the article, list of ingredients if composed of two or more, and the amount or percentages of each restricted ingredient. Since food grade phosphates, only, are allowed in processed meat products, only phosphates marked "Food Grade" shall be accepted for use. All materials should be enclosed in a sanitary container and should show the name and address of the manufacturer. Use of the materials should be prohibited if these requirements are not satisfied.

Acceptance for use of these materials will depend on their type. Most material will fall in one of two categories:

A. If the material is a lubricant, paint, or of a class of chemical compounds listed in the Technical Services Division publication, "List of Chemical Compounds Authorized for Use Under USDA Poultry, Meat, Rabbit, and Egg Product Inspection Program" samples should not normally be submitted to the laboratory. When the inspector checks the manufacturer's label and is able to locate it in this publication, he can normally assume it is acceptable. If the chemical compound identified by the manufacturer's label is not in this publication, he should reject its use until such time as he is supplied with a copy of the letter of approval which was given to the manufacturer indicating Technical Services Division Laboratory Branch acceptance of the product. This letter should be maintained in the inspector's files until the compound appears in the publication of approved materials. If the inspector has reason to believe the material is different from that which was authorized for use, he may send a sample to the Technical Services Laboratory, C&MS, USDA, Box 348, Beltsville, Maryland 20705.

B. For classes of materials not appearing in the Technical Services Division publication, periodic sampling is necessary. Samples should be sent to the regional Technical Services Laboratory servicing the area. This would include such items as flavoring, batters, curing agents, branding ink, etc. When a routine periodic sample is collected, the material sampled need not be retained; provided a history of acceptability has been established by previous laboratory examinations. However, if the material is being sampled for the first time it should be retained pending laboratory findings.

Should the situation arise where the inspector has knowledge that a subsequent lot of material in either category is different from previous shipments, he should withhold acceptance until necessary approval has been obtained. Also, if the inspector's examination reveals any unacceptable condition, the material should be rejected.

The Form MI-422-6, Approved Nonmeat Product, shall be applied to material that is acceptable.

If there is suspicion that subsequent lots of materials in either category is different from previous lots, the material should be retained until approval is obtained. If inspector's examination of materials reveals any unacceptable condition, the material should be rejected.

For instructions on sampling and maintaining sample records see Part 318.70.

318.17 Nonfat dry milk has been approved for use with proper declaration in sausage and meat loaves. Dried buttermilk and calcium caseinate have not been approved for use in meat food products. Mixtures of nonfat dry milk with other substances except as a minor ingredient of complex mixtures such as gravy or breeding mix are not acceptable.

318.18 No mixture containing albumin from inedible material has been approved for use in meat food products. Dried whey (food grade) conforming to the standard adopted by the Technical Services Division and sodium caseinate have been accepted for use in the preparation of loaves (other than "Meat Loaves"), stews, soups, and imitation sausage. Dried whey and sodium caseinate should not be accepted into official establishments when mixed with other substances except as a minor ingredient of complex mixtures.

The importance of adulteration with sodium caseinate in sausage and meat loaves is due not only to the use of an unacceptable ingredient, but because of its high protein content it facilitates adulteration of product with water.

Inspectors should develop and enforce specific control measures to prevent use of sodium caseinate in sausage and meat loaves. The control measures should be designed to operate effectively considering the facilities and method of operation of each sausage department. The basic features of the control should include:

- A. A continuous inventory of the amount of sodium caseinate on hand in the establishment and the amount used daily.
- B. A determination that seasoning materials are not adulterated with sodium caseinate.
- C. Sodium caseinate is not brought into the establishment under another name.
- D. A daily balancing of the amount of product which legitimately contains sodium caseinate and the amount of this material actually used.
- E. Occasional requests for sodium caseinate analysis in samples submitted for laboratory examination.

Meat Inspection supervisors should assist inspectors when necessary in developing adequate controls and assure themselves that such controls are continuously in effect. When inspectors are rotated on assignments, care should be taken to see that the control procedure is understood and operated effectively by the new inspector.

318.19 Lye solution for removing the outer surface of vegetables is permitted provided the lye solution is completely removed before the vegetables are processed further.

318.20

- A. Salt containing approved kinds and quantities of an anticaking agent may be used. These agents are usually tricalcium phosphate, calcium carbonate, or magnesium carbonate, used singly or in combination. However, this permission does not cover the use of these agents as such in meat food products.
- B. Salt which comes in contact with meat or product should be clean and free from extraneous materials, including rock or slate particles normally found in rock salt. The commonly used recrystallized or vacuum-pan granulated salt, with or without anticaking agent, is acceptable for this purpose.
- C. Salt solutions used for curing, defrosting, or for wetting cloths prior to application to dressed carcasses should be clear. The salt used to prepare the solutions should be free from extraneous material which indicates contamination with filth but may contain insoluble mineral matter such as slate or rock particles.

D. Salt should be handled so as not to become soiled. Bins or other facilities for the storage of salt should be constructed in a sanitary manner so that they may be readily cleaned and will protect the salt from contamination.

E. The equipment used for preparing salt solutions should be of sanitary construction and should be maintained in clean condition to avoid contamination of the solutions.

318.21 The congealing property of gelatin restricts its use in meat food products to those in which it would normally be an expected ingredient such as souse, jellied beef loaf, canned whole ham, etc. When used in canned hams, picnics, etc., it should be added in a manner to insure a fairly constant level uniformly distributed. This may be done by weighing, measuring or otherwise metering. When sampling, the amount of added gelatin should be reflected in the MI-422. Gelatin may also serve as a coating for such products as cooked hams and loaf products. However, it is not an acceptable ingredient of sausage.

318.22 Glycerin may not be added to product.

318.23 The Regulations provide for the addition to products of nitrates of sodium or potassium as well as nitrites of sodium or potassium. The desirable action of the nitrates on or in products is contingent upon their conversion to active form as nitrites. Therefore, the addition of nitrates is limited to that amount which under normal conditions will not by conversion of the nitrates into nitrites result in the presence of nitrite in excess of the amount permitted in the Regulations. Addition of excessive amounts of nitrates serves no useful purpose and is not permitted.

When commercial curing compounds containing nitrites are received, they may be released for use in the official establishment only if the manufacturer has indicated on the container that a sample of the lot from which this compound was derived was chemically analyzed and found to be acceptable and within the nitrite limitation on the label. In the absence of this kind of certification, the inspector will not permit the entry of such curing compounds onto the official premises.

This does not change the traditional sampling applied by the inspector to assure acceptability of the curing compound. In order to fully exercise his responsibilities, the inspector must periodically submit to the Meat Inspection Laboratory samples of shipments of curing compounds even though certified as described above. The laboratory determines the acceptability of mixtures containing nitrates, nitrites, or combinations of these, which are compounded for use in official establishments. The laboratory will also furnish information to the inspector regarding the amount of such mixtures that may be used. However, this amount will be based on the premise that the product will be pumped at 10 percent of green weight. If the establishment wishes to pump at other than 10 percent, the amount of the curing mixture must be adjusted accordingly. For example, if the establishment pumps 20 percent, the amount indicated by the laboratory must be divided by 2 since the ratio 20 to 10 is 2 to 1.

318.24 When papain or other approved proteolytic enzymes in combination with or without seasoning materials are used on steaks and other meat cuts which are frozen or cooked within the establishment, the product should be handled in a manner that will control the action of the enzyme material. The solution should not be used in a manner that will result in adulteration of product and the presence of the enzyme material as well as other ingredients that are added must be shown in the ingredient statement.

The inspector is expected to check enzyme treated meats which are treated by the process of ante-mortem injection as well as by dipping or injection into the boneless cuts. To facilitate this test, the establishments preparing these products should install equipment to demonstrate tenderness in the treated product.

Approximately 4-ounce samples of enzyme treated and untreated diaphragm or other muscle are placed in waterproof plastic bags. The bags are placed in a water bath with a temperature of 60°C. (140°F.) when bromelin is the predominant enzyme, or 67°C. (153°F.) when papain predominates. A slight deviation in the water bath temperature does not affect the test. After four hours of incubation, the samples are removed from the water bath and the extent of proteolytic activity is determined. The untreated control samples should remain firm and rather tough. The treated samples should demonstrate moderate to extensive proteolysis as indicated by the ease with which the muscle fibers are parted (a loosening and/or softening of the intermuscular connective tissue).

The water bath equipment need not be elaborate. However, it must be capable of maintaining a relatively constant temperature. A maximum-minimum indicator thermometer in the water bath would be helpful in determining the water temperature variation. Papain is active in a temperature range between 140°F. (60°C.) and 185 F. (85°C.); bromelin between a temperature of 86°F. (30°C.) and 140°F. (60°C.). During the conduct of such a test for inspectional evaluation, the equipment should be secured in a manner that would prevent interference with the tested samples. The water bath may be equipped for sealing as one acceptable method.

This technique is intended to disclose treatment techniques that do not result in proper proteolysis of the product. If the sample indicates improper enzymatic activity, the establishment should be informed so that corrective action can be taken. If the results consistently show improper enzymatic activity, the matter should be referred to the Labels, Standards and Packaging Branch of the Technical Services Division.

Inspectors may still submit occasional samples of treated and untreated meat, and enzyme solutions to the Microbiology Laboratory at Beltsville, Maryland.

318.25 Most establishments preparing product containing beans have facilities for cleaning, picking, or otherwise eliminating unsuitable beans from a lot prior to inclusion in a meat food product. Therefore, when lots

Section 318.25

of beans are received at an establishment having such facilities, the beans should receive a preliminary inspection and may be brought into the establishment unless found to be affected with a condition such as heavy mold, sourness or weevil larvae, webbing, or refuse which could not be removed by the cleaning procedures. Beans from an accepted lot should not be used in product until the cleaning process has removed all foreign material (stones, dirt, weed seeds, and cereal grains) and beans damaged by insects. Beans less severely damaged by insects (in which the seed coat is slightly affected) and those slightly damaged by frost, weather or disease may be included in product. Broken beans and beans with the seed coat partially or wholly removed may also be included. Establishments not having bean-cleaning facilities should receive only beans entirely free of defects that make them unsuitable for inclusion in products. All beans should be thoroughly washed before use.

318.26 Certain seasoning preparations contain various amounts of dried corn syrup, dextrose, and the like. In the enforcement of the requirement that not more than 2 percent of dried corn syrup or corn syrup solids be used in meat food products such as sausage, hamburger, meat loaf, luncheon meat, chopped ham, and pressed ham, inspectors should take into consideration the amount of such sugar added to product by the use of seasoning preparations. Inspectors should make use of the laboratory for determining the amount of sugar other than sucrose or dextrose in the seasoning preparation when this information is not shown on the label. The amount of corn syrup solids in pickle is limited to 50 pounds per 100 gallons based on the dry weight. Since corn syrup contains about 20 percent water, 60 pounds of corn syrup may be used. These amounts should be adjusted when pumps other than 10 percent are made.

318.27

A. Thermocouples connected to recording equipment may be used for taking temperature of products that are heated to destroy possible trichinae provided the inspector has assured himself by checking the thermocouples with an official thermometer that the temperatures recorded are accurate. Placing thermocouples in product must be under the supervision of an inspector and an adequate number of thermocouples must be used to determine that all product in the smokehouse reaches the necessary temperature. In permitting use of this equipment, the inspector must assure himself that there is no possible way of recording a temperature that was not obtained in the product being treated for trichinae.

Section 318.10 (c)(1) of the Meat Inspection Regulations requires that pork muscle tissue be heated to a temperature not lower than 137°F. The inspector must therefore know that all such product is adequately heated. When it is determined that a cold spot exists in a heating chamber, the establishment should take such action as may be necessary to eliminate it. Defects in the number or location of heating coils or air ducts in a smokehouse or lack of proper insulation of the heating compartment or unit are the usual causes for cold spots. Some difficulty may also result from uneven loading or distribution of the product in the heating compartment.

When taking the temperature of product, care must be exercised to obtain the lowest temperature in the product. Special attention should be given to the largest pieces of product or the innermost links of bunched sausage. In small varieties of sausage placed in direct contact with wooden smokesticks when the temperature of sausage is only slightly above 137°F., the temperature should also be taken of that part in direct contact with the wooden smokestick.

B. In some establishments equipment such as grinders, choppers, mixers, etc., are used interchangeably in the handling of pork which possibly contains live trichinae and products that are free of live trichinae. Necessary precautions must be taken to assure that those products that are free of live trichinae and which will be distributed from the establishment without further treatment are not contaminated with live trichinae.

318.28 Preparation—Curing, Smoking. Only clear solutions free from insoluble suspended material or other contamination should be injected into meat for the purpose of curing.

318.29

A. Cover pickle that is clear, free of sediment, and does not show evidence of decomposition may be reused. Pickle which escapes during the pumping of blood vessels or during the mechanical injection of curing solutions may be reused under proper conditions. These conditions include sanitary collecting equipment and efficient filtration (faint hemoglobin color permitted) before mixing with new pickle. All pickle lines should be made of stainless steel or approved plastic and those carrying salvaged pickle must be demountable for cleaning at regular intervals.

B. Monosodium glutamate or hydrolyzed plant protein may be added to the pumping pickle, cover pickle, or dry-cure mixture for cured meats. When used in such cured meats as hams, bacon, pork shoulder picnics, cured beef, and tongues, no change is required in the labeling.

C. When samples of cured meats containing monosodium glutamate or hydrolyzed plant protein are sent to the laboratory for analysis, the inspector should furnish information on Form MI-422 concerning the amount of monosodium glutamate or hydrolyzed plant protein used for each 100 pounds of finished product.

D. To standardize our requirements and to preclude the possibility of adulteration of cured pork and beef products, it has been decided to limit the amount of corn syrup solids or corn syrup in pickle to 50 pounds per 100 gallons based on the dry weight. Since corn syrup contains approximately 20 percent water, 60 pounds of corn syrup is considered to be equivalent to 50 pounds of the solids.

318.30 Cured hams intended for canning may be shipped from one establishment to another if shipments are properly identified to the receiving Officer in Charge. To do this, hams should be accompanied by a properly modified Form MI-408-1 which indicates that they are eligible for canning in accordance with applicable regulations.

Section 318.31

318.31 Cured boneless pork loins and sizable pieces thereof which have been treated for the destruction of possible live trichinae may be shipped provided they bear the marks of inspection. It is not necessary that they then be forwarded in sealed containers or sealed vehicles.

318.32 Official establishments should provide adequate facilities for the control of boneless pork loins during the curing process or adopt operating practices that will eliminate any possibility of shipping untreated cured boneless pork loins.

318.33 A cured, boned, and rolled whole ham, unsmoked, either tied or in a casing, is commonly termed "Scotch Style Ham" in certain localities. As Scotch Style Hams are customarily well cooked in the home or elsewhere before being served, they need not be treated for the destruction of trichinae.

318.34 Section 318.7(r) of the Regulations provides for the addition of phosphates to pumping pickle for cured hams and pork shoulder picnics. This has been extended to include cured pork shoulders, Boston butts, boneless butts, pork loins, and bacon.

318.35 The Armed Forces desire at times to purchase smoked hams smoked at temperatures sufficiently high to impart a partially cooked appearance to the meat. We have acceded to their request not to require such product to be treated to destroy possible live trichinae as contemplated by Section 318.10 of the Meat Inspection Regulations when such ham is to be consigned to Armed Forces. However, the Regulations remain in full effect as they apply to smoked hams that are not consigned to the Armed Forces or tropical climates. Smoked hams prepared for delivery to the Armed Forces must not be diverted into channels of trade until they have been treated by one of the methods prescribed in the Regulations for destruction of trichinae.

318.36 Preparation--Canning. The requirement of Section 318.1(b)(1) of the Regulations does not change the status of such relatively stable products as lard, sliced or slab bacon, sliced dried beef, and the like, which are sometimes distributed in hermetically sealed containers.

318.37 Devices for measuring temperature, including thermocouples and various types of thermometers, are available at official establishments for taking temperatures of product during processing. Inspectors may make use of any such devices in their inspection work, providing they have been checked adequately against an official thermometer to insure accuracy and dependability. When distant reading devices such as thermocouples are used for measuring the temperature of product, the sensitive element must be placed in the coldest part of the product just as is done with thermometers.

318.38 There should be a close synchronization of can-filling lines and heat processing. It is not sound practice to produce at the filling lines beyond normal retort capacity. This may cause a delay in heat processing or a

tendency to hurry some phases of the heating operations. The type and temperature of the canned product as well as the size of the can are some of the factors that must be considered in determining how promptly the product must be heat processed after closing. Cold-packed products should be maintained at a low temperature until heat processing begins.

The following restrictions apply to hermetically sealed, canned product processed and labeled under a "Perishable, Keep Under Refrigeration" statement:

A. No approval has been given for canning uncured products under a "Perishable, Keep Under Refrigeration" warning statement.

B. Cured, unsmoked, boneless pork shoulders, pork shoulder butts, boneless hams or luncheon meat may be canned without steam pressure, cooking, provided the labeling "Perishable, Keep Under Refrigeration" is used. This includes such products in cans having a net weight of 12 ounces or more. The acceptable method of preparation of such product includes curing the product prior to placing it in the can and subjecting the canned product to a cooking process which will assure that an internal temperature of at least 150° F. is obtained. The statement, "Perishable, Keep Under Refrigeration," shall be shown prominently on each principal display panel of labels for such canned product.

C. Cured meat loaves, cured nonspecific loaves and similar cured products, the formulas for which do not include cereal or starch, may be canned under this type of processing provided the formula includes 1 ounce nitrate per 100 pounds product, 1/2 percent dextrose or 1 percent sugar, and the finished product demonstrates a brine concentration* of not less than 3.5 percent. An internal temperature of 150° F. must be attained during processing in hot water.

D. Cured meat loaves, cured nonspecific loaves and similar cured products containing cereal, starch or similar extenders must meet the same restrictions outlined in paragraph C, except in addition, the brine concentration* must not be less than 6 percent. (* The brine concentration is calculated by dividing the amount of salt by the sum of the total water and the salt. This will be determined by the chemical laboratories upon request.)

In addition to temperatures and other factors outlined above, the inspector must examine samples of finished product to satisfy himself it exhibits usual cured characteristics. The addition of nitrate alone immediately prior to canning may not result in a cured product.

Some of the known environmental factors which influence the germination and growth of microorganisms include temperature, salt concentration, pH, presence or absence of starch, sugar, nitrate, nitrite, kind and numbers of microorganisms, etc. The relative importance of each factor in relation to the total other factors is not well established. The numbers and kinds of organisms in cured canned "Perishable" meat items are of great importance; therefore, the inspector should be particularly alert to see that cured product ready for canning is fully sound and has not been handled in a questionable manner.

Section 318.38(D)

If sweller cans develop in a lot under normal handling conditions, the code should be determined and an unopened can submitted to the Microbiological Laboratory for evaluation together with full information pertaining to the production of the canned product to be evaluated.

318.39 Ample but not excessive head space should be allowed in hermetically sealed containers. Deceptive filling of containers cannot be condoned. Over-filling cans should be avoided.

318.40 Make periodic checks to determine that cold spots do not exist in the heat processing equipment. Exhaust boxes should receive attention as to cleanliness and adequate heating apparatus. There should be free circulation of heat throughout.

318.41 It is not necessary to exercise close supervision over the internal temperature of sausage prior to canning when it is known that such product will be subsequently canned with adequate heating.

318.42 Canned product should be handled, stored, and shipped so as to avoid damage from extremes of heat or cold, rusting, and denting.

318.43 The repacking and reprocessing of contents of defective cans which have been handled as outlined in section 318.11(d) of the Meat Inspection Regulations should include processing by heat fully equivalent to the original processing.

318.44 Establishments may process certain canned products without steam pressure cooking after they have obtained permission from the Director of the Processed Meat Inspection Division. Such products must have been prepared in accordance with methods of preparation shown on approved labeling material for this type of product. This includes use of the ingredients and the development during processing of internal temperatures as specified in the label approval. In addition, labeling should include the perishable warning statement.

318.45 Canned product that is not processed after canning, which has a minimum acidity of pH 4.5, may be prepared in official establishments providing permission of the Director of the Processed Meat Inspection Division has been obtained. Further, such product should be prepared in accordance with methods of preparation shown on approved labeling material for this type of product. pH values should be determined by laboratory analysis.

318.46 At least one container from each basket in a retort should be incubated as a sample of a lot of processed canned product. Incubation of test samples should be accomplished in an acceptable room or compartment held under Government lock. Incubation of a certain sample may be discontinued before the full 10-day period has elapsed if it becomes apparent that the product does not possess the necessary stability to assure its keeping under usual conditions of handling, storage, and transportation. Corrective action regarding the lot should be started at once. Sample incubation is not always

positive proof of the character or stability of the entire lot, and it should be used in addition to, but not in lieu of, constant vigilance and supervision of all processing procedures. There should be no hesitancy to increase the number of cans selected for incubation if there is cause for such action. Careful inspection of product being incubated should be made at least daily.

318.47 Restrictions on the use of water or ice in the preparation of luncheon meat and meat loaf are extended to canned chopped ham, canned chopped pork generally, and canned chopped mixtures of pork and other meats. The quantity of water or ice that may be added to luncheon meat and similar products is based on the percentage of ingredients going into the preparation of the product. Therefore, strict control is exercised at the time of preparation and is not based on the finished product. The amount of water used in the fabrication of the product should be listed in the ingredient statement according to its percentage at the time of manufacture and not as it occurs in the finished product.

318.48

A. The use of efficient jet-vacuum type equipment has been accepted for cleaning jars and cans before filling in lieu of cleaning with hot water as required by the Regulations. The air cleaning method involves the direction of a powerful stream of filtered air into the open top of the upright container immediately followed by complete evacuation of the container by means of a vacuum-producing device. In properly functioning equipment, the air jet dislodges dust, particles of cardboard and other extraneous material and the vacuum removes these materials just as effectively as the conventional hot water cleaning methods.

Since it is difficult to determine if the cleaner is functioning properly, it is required that such equipment be equipped with safety devices to indicate malfunctioning of either the jet or vacuum-producing parts.

It is also required that the empty containers should be removed from shipping cartons and fed onto the conveyor passing through the cleaner at a location protected from the exhaust currents from the cleaner since it is likely that dust and carton fragments deposited on the unloading table will be blown into the air and deposited in the container after cleaning and before filling. If this is not possible, other means acceptable to the Officer in Charge must be taken to properly control the exhaust currents; for example, venting the exhaust ducts to the outside.

B. Analysis of various contaminants found on hams in Pullman-type cans revealed the contaminants fell in three areas: Small solder splatter pellets; small particles or flakes from the inside can lacquer; and various contaminants and dirt from unclean project or cans.

The tiny solder splatter pellets constitute the minor part of this problem and can manufacturers have been contacted to eliminate or at least greatly reduce this problem in the future. Particles of interior can lacquer might be loosened when the can is placed on the stuffing horn. Close attention

should be given to the condition of the stuffing horn to see there are no sharp rough edges which might cause the lacquer to flake.

The major problem appears to be paper lint or dirt which was not removed from the can in the normal can washing operations. Apparently, can washing facilities designed for shallow cans do not begin to accomplish a thorough washing of the long Pullman-type can. Inspectors are alerted to give this full attention. If necessary, the can washing facilities should be redesigned to insure a large amount of flushing water to all parts of the can. Mechanical brushing may even be necessary to accomplish the desired results.

C. Process water for canned meats may contain not in excess of 600 ppm of sodium nitrite to inhibit can corrosion. The following additions will give a concentration of 600 ppm.

1. 0.56 oz. of sodium nitrite in 1 cu. ft. of water.
2. 6 oz. of sodium nitrite in 78.1 gallons of water.
3. 7.8 oz. of sodium nitrite in 100 gallons of water.

The sodium nitrite intended for this purpose must be decharacterized by the addition of .05 percent of powdered charcoal. Bulk decharacterized sodium nitrite in the cook room shall be held in a locked metal bin or container conspicuously labeled "Decharacterized Sodium Nitrite To Be Used By Authorized Personnel Only."

318.49 Preparation--Sausage. Finished casings prepared at unofficial establishments may be received into official establishments and used as containers of meat food products provided they present no objectionable condition. Unsound casings must be rejected. Animal casings of foreign origin should not be rejected solely because of their dark color. Casings are inspected when they are presented for use as containers. Sewed animal casings should be carefully examined before use, particularly at the inner seams. Excessive fat should be removed from animal casings before use. Hog bungs should be free of hair and scurf at the crown end.

318.50 Animal casings for use as containers must be thoroughly flushed throughout their entire length before stuffing. Whether this can be done singly or collectively can be determined at the establishment by the inspector. Animal casings that have been flushed prior to receipt at the establishment and are packed in a salt solution or slat and glycerin solution may be used as containers after thorough rinsing and without additional flushing if found to be acceptable by the inspector. Materials such as antibiotics, antioxidants, preservatives, nitrite and nitrate are not permitted to be in preflushed casings used at official establishments. A laboratory analysis for these materials should be requested occasionally.

318.51 If the lips from cattle, calves, sheep, and goats are used in the preparation of meat food products, they should be chopped to a fineness that completely destroys the conical shape. Where conventional type choppers are

used experience has demonstrated that the shape of conical papillae cannot be destroyed with certainty unless the lips have first been cooked and the mucous membrane has been removed.

High-speed emulsifying grinders appear to destroy the identity of the control papillae without prior cooking. Where this has been accomplished to the satisfaction of the inspector, the requirements of scalding and removal of the mucous membrane from lips may be omitted.

318.52 The following are not considered normal ingredients of sausage: Eggs, cheese, pickles, macaroni, vegetables. Blood, kidneys, and detached skin are not to be used in the preparation of such types of sausage as bologna, frankfurter, vienna, and braunschweiger.

318.53 The application of approved clear mineral oil or edible vegetable oil to the outer surface of dry or semidry sausage casings as an inhibitor of mold formation has been accepted. Such application must be made after the prescribed treatment for the destruction of possible live trichinae has been completed on applicable products.

318.54 Product prepared with meat byproducts to the exclusion of meat cannot be regarded as sausage.

318.55 The proportion of a condimental substance that may be added to sausage to augment its palatability is dependent on many variable factors. Substances having a strong pungency, aroma, or appetizing quality should be in lesser proportion than substances having those qualities in lower value. On the other hand, condiments, especially those highly colored, should not be added beyond their usefulness as such. For instance, paprika and oil extracts or emulsion of paprika have a low pungency, so a product to which these are added may be considerably altered in color before the condimental effect is apparent. In such a case, coloring properties must be taken into consideration along with seasoning value to determine the proportion that may be used in any given product without producing a deceptive condition with respect to the quality, kind, or amount of meat used in the product. A larger amount of the condiment may be used, however, if it is considered a customary ingredient of a specific product.

318.56 Equipment used in the preparation of sausage containing cereal or other permitted materials of similar kind should be made acceptably clean before it is used to prepare product not containing such additives.

318.57 Cereal is not a permitted ingredient of thuringer or corned beef hash.

318.58 Meat byproducts, cereal, and nonfat dry milk are not permitted in mettwurst.

318.59

A. It is important to differentiate between the basis on which water may be added to sausage which is not cooked and that which is cooked. Sausage which is not cooked may contain up to 3 percent of added water, based on the total ingredients used in the preparation. The added water is not calculated on analysis of the finished product but on the percentage of materials going into its manufacture. On the other hand, cooked sausage may contain up to 10 percent of added water, as determined by analysis of the finished product.

B. Frankfurters and vienna sausage to be packed in water, or brine, or meat broth, or meat stock, or barbecue sauce must comply with moisture requirements before canning. When water or brine is to be the packing media, the quantity of sausage equal to the net weight specified on the label shall be placed in the can. When meat broth, or meat stock, or barbecue sauce is to be the packing medium, the sausage component placed in the can shall comprise 80 percent of the total net content calculated on the basis of the total net content statement on the label, applied to, or to be applied to the can.

318.60 The use of monosodium glutamate or hydrolyzed plant protein does not in any way alter the amount of water that may be used in the preparation of luncheon meat, meat loaf, and fresh sausage, nor in the amount of water that may be present in cooked and smoked sausage. When samples of such meat food products are sent to the laboratory for analysis, information should be furnished by the inspector on Form MI-422 concerning the amount of monosodium glutamate or hydrolyzed plant protein used for each 100 pounds of finished product. For each ounce of monosodium glutamate or hydrolyzed plant protein used per 100 pounds of finished product, 1/16 of 1 percent will be deducted from the total protein before computing the amount of added water in the product.

318.61 Unskinned pork jowls which are free of hair roots may be used to the extent of 50 percent of the meat formula in the preparation of vienna sausage, frankfurter sausage and bologna sausage. The unskinned jowls shall be ground to the fineness necessary to prevent a change in the character of the finished sausage.

318.62

A. As outlined in Part 318 of the Regulations, sausage shall be prepared with meat and meat byproducts. Since smoked meats are considered meat food products, they are not eligible for use in sausage except that byproducts of the industry, such as bacon ends and pieces and trimmings from other cured and smoked meats may be included in such products as cured sausage, luncheon meat, loaves, chopped pork and the like to the extent of 10 percent of the meat and meat byproduct portion of the formula. Any phosphate introduced by this means will be present in such negligible amounts that no useful purpose would be served by a label declaration. In such products for which our standards of composition permit only 3 percent water to be used in their preparation, it is necessary that the moisture included with the trimmings be considered in determining compliance.

B. Rework of fresh pork sausage and similar type product enclosed in edible collagen casings may be used in the production of emulsion-type sausage, such as frankfurters, without removal of the collagen casing providing the product is sound, wholesome, and otherwise acceptable. Since collagen is a normal constituent of meat, it is only necessary that its character be altered to blend and dissolve in the emulsion. When the type of processing is such that the ingredients are finely chopped or emulsified, as in the production of frankfurters, it has been demonstrated that this is accomplished.

318.63 Mustard, because of its low potency and high protein content, shall be limited in sausage and meat loaves to not more than one percent based on the weight of the finished product.

The use of spices and seasonings or mixtures thereof in certain meat food products should be restricted so that no more than 0.35 percent protein is added. The limitation applies whenever the protein content serves as a basis for some form of control such as calculating added water, added substances, trimmable fat, water-protein ratios and phosphorus blanks.

The protein content of permissible spices and seasonings is such that if the amount used in the product is less than 1 percent, no more than 0.35 percent protein will be added. If the amount used is greater than 1 percent, is unknown or if prohibited high protein additives are suspected, a sample should be submitted to the Meat Inspection laboratory for protein determination. The laboratory will make the analysis and report the maximum amount of the preparation which may be used without exceeding the 0.35 percent protein limitation.

It is recommended, where practical, that samples of spices or seasonings and mixes be taken just before addition to the product.

318.64 When water is used as a solvent for the nitrate ingredient and so added to gain a more even distribution of the curing agent, or when wine is added principally as a flavoring to certain kinds of sausage processed under limitations prescribed in subparagraph 318.10(c)(3)(i) of the Regulations, it is permissible to add not more than approximately 1/4 of 1 percent of water or 1 percent of wine to sausage of the type that is treated for destruction of possible live trichinae by any one of the methods prescribed in subparagraph 318.19(c)(3)(i) of the Meat Inspection Regulations. When used, such ingredients should be shown in the statement of ingredients in the order of their percentage content.

318.65 Acidification with vinegar, lactic acid, or citric acid of approved dye solutions for application to casings is permitted.

Solutions of 5 percent citric acid or 35-40 grain vinegar may be used for spraying frankfurters prior to or after smoking to improve peelability. The solutions may be recirculated during the days operation if it is effectively filtered and has a clear appearance. The equipment used for this purpose must be constructed of approved plastic or stainless steel and the spray heads, filters and pumps must be demountable to facilitate cleaning.

318.66 Artificial casings impregnated with soluble approved dyes may be used in official establishments for the small varieties of sausages under the provisions of Section 318.7(m) of the Meat Inspection Regulations. The certification required for coal tar dyes under Section 318.7(B) of the Regulations should be furnished with each lot of such dye-impregnated casings.

"Blow-out" sausage, the sausage resulting from broken casings, and that which is stripped from the ends of the casings in order to effect the tie, may be reworked into subsequent lots of the same kind of sausage provided there is no perceptible coloring of the finished sausage as a result of the inclusion of this material.

318.67 The inspector should examine the products for color penetration before the products leave the establishment. Corrective action if indicated should be taken before the product is shipped. Laboratories should not be asked to examine product for color penetration.

318.68 Preparation—Permitted and Prohibited Ingredients. Ingredients such as dried or candied fruits, dehydrated vegetables, and fruit juices containing small additions of sodium benzoate or benzoic acid, sodium sulfite or sulfur dioxide, or combinations of these for the purpose of preserving the ingredient may be used in the preparation of those meat food products in which such ingredient is customary. For example: Dried or candied fruits, including maraschino cherries, may be used for decorating cooked smoked pork cuts; dehydrated vegetables for preparing soups and hashes; and fruit juices for flavoring certain stews and soups. These preservatives need not be declared on labeling material for meat or meat food product.

318.69 Approval of soy flour, soy protein concentrate, and isolated soy protein as an ingredient of sausage is based upon the binding properties of the substances. These materials consisting of the soy product in finely divided form without additives have also been permitted as ingredients of other meat food products such as chili (as a thickening agent), stew, loaves (other than meat loaves), soups, etc.

Soy product manufacturers are now offering products of the isolated soy protein, soy protein concentrate, and soy protein categories that have been modified by adding such substances as beef extract, spices, flavors, and colors, alone or in combination, to the soy product. The modified soy product is sometimes formed so as to have the appearance of meat which has been ground, flaked, chopped, or diced. Differentiation by sight of the modified soy products from ground or flaked meat is difficult when they are present in processed meat food products.

Soy products that have the appearance of diced, flaked, or ground meat, even though labeled as "soy flour," "isolated soy protein," "soy protein concentrate," or "soy protein" should not be used in the formulation of a meat food product unless specifically approved by the Labels, Standards and Packaging Branch of the Technical Services Division. Inspectors must exercise constant vigilance to assure that such materials are not improperly used in the formulation of meat food products produced under their supervision.

In all cases, the soy products must be identified by their common or usual name in the statement of ingredients and/or product name (as required by regulations or label approval.) Soy bean derivatives for which the category or protein content is questionable should be submitted for laboratory determination. Soy protein concentrate, soy flour and isolated soy protein are practically indistinguishable by visual examination. They may also closely resemble sodium caseinate, nonfat dry milk and certain cereals. Therefore, if the establishment stocks more than one type of soy product, additional controls are required. These include developing with the establishment a procedure for confining soy products for positive identification and maintaining daily records showing amounts of soy bean derivative used and the type of product being prepared.

318.70 Preparation - Sample, Samples.

A. Meat inspection laboratories, maintained for analyzing samples and performing other special examination of products, ingredients, and materials provide the inspector with information he needs to be sure that all products under his supervision are prepared according to the Regulations. Certain commercial chemical laboratories have been approved by Technical Services Division for official chemical analyses of smoked pork products. When establishments elect to use an approved commercial laboratory, all routine samples for that type product should be submitted to that laboratory. Commercial laboratories cannot be used solely for occasional or emergency sampling because this usage will not furnish the broad background needed to evaluate the sample preparation and laboratory technique.

B. The inspector must be continually alert to detect substances, such as those contaminated by rodents, insects, molds and dirt, that are unsuitable for inclusion in food. The detection of such contamination often does not require a laboratory examination. Materials such as seasonings, spices, and cereals have been found infested with insects in various stages of their life cycle when received at official establishments. In other instances, infestation has been found after the material has been in storage in the establishment and could occur when fresh supplies are placed in bins or containers that are infested. At some stages (adult, larval and pupal), the insects are very small and could be easily overlooked. While most infestations can be detected by giving these materials a very careful examination before use, inspectors should frequently send samples to the laboratory where a more thorough examination can be made to determine acceptability.

Since some foreign matter cannot be detected by visual inspection, samples of flour, spice flavorings, curing materials, nonfat dry milk, tomato puree and the like should be sent to the laboratory for examination.

C. Part 317 of the Meat Inspection Regulations gives the minimum requirements for a number of prepared products, so that the inspector can control the preparation of every batch of product. The Regulations also specify the fat content of hamburger and fresh sausage and the gain permitted in hams for canning. The laboratory may be used for checks on such products, but the primary control is vested in the inspector in the establishment.

D. When not more than the permitted amounts of curing materials are added to product, there should be a few violations for excess nitrite. Sufficient checks of finished product should be made, however, to know whether the conversion of nitrate to nitrite has been greater than normally expected.

E. The inspector should not be concerned with the ability of a particular laboratory to handle necessary samples. Any adjustments in this respect will be made by the District office.

F. Samples may be collected any day of the week. Obviously, the collection of samples should not follow a definite schedule. Care should be taken to have samples of perishable products arrive at the laboratory in good condition.

G. Samples taken for laboratory analysis should be truly representative of the entire lot. The sample should be properly identified from the time it is taken until it reaches the laboratory. Information on Form MI-422 which accompanies the sample, must be fully explanatory and include the name of the product as it will be labeled, the list of ingredients in the order of their percentages at the start of preparation, and the establishment from which the product originated. In most cases the sample should be taken from finished product, although investigational samples may be collected at any point in the operation. In the case of proprietary mixtures, a list of the ingredients as they appear on the shipping containers, the name and address of the manufacturer, and the purpose for which the material is intended should be noted on the laboratory form. Dry mixtures should be submitted in the smaller size plastic film bag (approximately 3 by 6 inches flat) and the bag should be almost completely filled. Liquid materials should be submitted in the conventional 4-ounce sample bottle. If a shipment consists of more than one bag, barrel, or other container, a proportionate number of samples should be taken at random throughout the lot. Any article received in an establishment and not identified by name and ingredient statement should be withheld from use until satisfactory identification has been made.

H. When sampling cereals, spices, and similar materials, the inspector upon opening the package should remove and examine a sufficient portion of the contents to ascertain whether the article is uniform throughout and to make sure that the sample represents the lot. Unfit materials should be rejected. Laboratory analysis of articles known to be unacceptable usually serves no useful purpose.

I. A check procedure for sampling non-meat materials for the presence of prohibited chemicals and adulterants is important. This is emphasized by finding of sulphites and nitrites in the packing media of preflushed casings, ascorbates in fresh sausage, and the possibility of antibiotics being added in meat and meat food products.

The following procedure will be used in addition to samples regularly submitted by inspectors from suspicious lots or from individual containers:

The District Director or his deputy will be notified by PMID to arrange for the collection and submittal of 10 samples of non-meat materials from each identified circuit selected at random. This program will run concurrently with sampling boneless beef, veal or mutton for species identification. The

samples should be taken from containers of non-meat ingredients which have been batched for use in meat food products. Samples of preflushed casings if available should also be sent in at this time. The samples will be submitted to the chemical laboratory and request made for presence of ascorbates, sulphites, nitrites and/or any other material which may be included as an adulterant or preservative. Duplicate samples of non-meat ingredients should be sent to the microbiology laboratory for antibiotic analyses.

J. Plastic bags furnished by the Meat Inspection Laboratories should be used in lieu of metal cans as containers of meat and meat food product samples.

Approximately one pound of product should be placed in the plastic bag. Sausage and meat food products of the larger types need not be cut in small pieces. No paper or other absorbent material should be placed in the plastic bag with the sample. The top of the bag should be closed by twisting it, applying several loops of a rubber band and folding the twisted end over and applying one or two more loops of the rubber band. As much air as possible should be excluded from the package; however, the closure should be applied so as to leave some space in the bag around the sample. This will permit some expansion in case decomposition and gas formation occur during shipment. The closed plastic bag containing the sample should be placed directly on the usual mailing carton. Three or four samples may be placed in the carton.

K. All procedures in sampling should be so carried out as to provide the laboratory with as nearly representative a sample as is possible under practical operating conditions. Since no practical method of sampling can be considered entirely free from potential error, the inspector must evaluate the report he receives from the laboratory with full recognition of this possibility of error. There is bound to be a range in moisture content through a production of a batch of cooked sausage and instances where nonfat dry milk or cereal had not been uniformly distributed through the product. It is not probably that any one sampling by an inspector of a batch of product will truly represent the entire production of that particular kind of sausage. The inspector, therefore, must make allowances for such probability. Naturally, a laboratory report indicating that a sample of cooked sausage contains an amount of moisture, cereal, or nonfat dry milk considerably in excess of the Regulations limitation should be interpreted as a clear indication that the plant's production methods are faulty and immediate correction should be required. By contrast with this, when sample reports show the presence of excessive added moisture, cereal, or nonfat dry milk within narrow limits, the inspector may consider it necessary to obtain additional sample analyses of the sausage before he decides whether or not the methods used by the establishment will produce cooked sausage that conforms with the Regulations.

In addition to the above-mentioned variations, normal variations in laboratory analytical results is also a factor to be considered. The variations have been characterized in a collaborative study by Meat Inspection and

industry laboratories. On the basis of this study, moisture in a single sample might be expected (95 percent probability) to vary by plus or minus 2 percent.

1. Examples of analytical variance:

Added Moisture by Analysis (PERCENT)	Range of Added Moisture (95 Percent) Probability (PERCENT)
9	7 to 11
10	8 to 12
11	9 to 13
12	10 to 14

2. Interpretation of analytical results:

a. Analytical Result over 12 percent. The inspector should require immediate corrective action to reduce the moisture content of the sausage.

b. Analytical Result 11 to 12 percent. The inspector should carefully review all details of the moisture control routines. Changes in formulation or manufacture need not be required unless the review indicates that the added moisture had been increased due to changes in production. Additional samples of product from subsequent lots should be taken and if the results of two consecutive samples fall in this range, the inspector should take action as outlined in "a."

c. Analytical Results 10 to 11 percent. The inspector should continue the usual inspection routine but submit samples from subsequent lots. If the results of four consecutive samples fall in this range, the inspector should take action as outlined in "a."

L. The handling of decomposed samples by the Meat Inspection Laboratories is not only objectionable to the chemists and technicians but also adversely affects the accuracy of the analytical procedures for nitrite, non-fat dry milk, and sugars such as those contained in corn syrup solids. Unless perishable samples can be mailed immediately with assurance that they will not remain in the mail channels over a weekend or holiday before delivery to the laboratory or be otherwise unduly detained, the samples should be frozen or otherwise protected prior to mailing. Adequate control should be exercised during the time that the samples are being frozen to assure that there is no opportunity for manipulation of the sample collected by the inspector.

1. Certain stations located in a considerable distance from the chemical control laboratory serving them may find it necessary to forward samples to be examined for nitrite under refrigeration, such as might be obtained by packing the sample with dry ice. Chemists in Charge of laboratories should assist inspectors in developing satisfactory mailing procedures by reporting those occasions when the sample arrives in a decomposed condition.

In such cases it would probably be desirable to indicate the date and hour that the sample arrived at the laboratory.

2. When necessary, fresh products such as pork sausage and hamburger should be protected from decomposition by the addition of approximately 10 drops of formalin to the product at the time the sample is collected. The product and the formalin should be thoroughly mixed by kneading the package after it has been closed. When so treated the sample form should carry a statement such as "10 drops formalin added."

3. If a perishable sample is to be transported in excess of 200 miles, it should be shipped via airmail to insure efficient handling of sample. DO NOT SHIP BY AIR EXPRESS.

- a. Clearly address the package by either printing or typing the name, address, and zip code of the recipient on a U. S. Government Frank (Form AD-11) and firmly secure the frank to the package.
- b. Securely fasten one POD Label 19 to each side of the package.
- c. Securely attach (where it will be clearly visible at all times) a POD Label 38 to the package.
- d. Where feasible, deposit the package at the local post office to expedite handling.
- e. POD Label 19 and Label 38 can be obtained from your local post office.
- f. Packages being mailed to the Microbiology Laboratory, Beltsville, Maryland, should be addressed as follows:

Microbiology Laboratory
C&MS, USDA
Box 348
Beltsville, Maryland 20705

318.71

A. A separate Form MI-422 is to be used for submitting and reporting each sample. In the designated space, the establishment number should precede the sample number. A new series of numbers, starting with number one (1), shall begin each July 1 for each meat and meat food product. Sample numbers for nonmeat items shall begin anew with number one (1) each July 1, but does not require a separate series of numbers for each product. Sample records shall be maintained in the following manner:

- 1. Charts for cured and smoked, cooked or canned pork product shall be used. Charts are discussed in 318.74.

2. Charts for all product, other than that specified in 1 above, shall be kept as illustrated in Example 2 following.

3. Charts for all nonmeat items, using our series of numbers for all product, shall be kept as illustrated in Example 3 following.

Product name shall be that shown on the label. Product code numbers are shown on MI-422-A, Example 1 following.

At the time the sample is submitted the sample number for each product shall be entered in the appropriate month column. When sample results are returned, the number on the chart representing that sample shall: (1) be crossed through with a diagonal line if it was in compliance (example 3), or (2) be encircled if it was a violation (example ③). Analytical results of product referred to in 318.70K may fall in one of three ranges. A sample result in "b" or "c" range should be recorded as being in compliance (example 3b or 3c); except, when such sample results falling in "b" or "c" range which requires the action that is specified in "a" the sample result would be recorded as a violation (example ③).

The same sample number and product code number may occur for more than one meat food product. In those cases, the correct product name shall be the identifying tool.

Example #1

PRODUCT CODES FOR LABORATORY SAMPLES

CURED BEEF PRODUCTS		BEEF COOKED		SAUSAGE SMOKED OR COOKED (Con't)	
CORNED BEEF BRISKET	1010 10	BEEF TONGUES	1210 10	SMOKED SAUSAGE	REGULAR 1340 51
CORNED BEEF	1010 30	MISCELLANEOUS	1210 90		CEREAL 1340 53
CURED BEEF TONGUES	1010 50	PORK COOKED			NFD MILK 1340 54
MISCELLANEOUS	1010 90				REGULAR 1340 71
CURED PORK PRODUCTS		HAMS	1220 10	POLISH SAUSAGE	CEREAL 1340 73
		PICNICS	1220 30		NFD MILK 1340 74
HAMS	1020 10	BUTTS	1220 50		REGULAR 1340 91
BUTTS	1020 30	MISCELLANEOUS	1220 90	MISCEL-LANEOUS	CEREAL 1340 93
PICNICS	1020 50	SAUSAGE FRESH FINISHED			NFD MILK 1340 94
MISCELLANEOUS	1020 90				
BEEF SMOKED AND/OR DRIED		PORK SAUSAGE	1310 10	HAMBURGER	
		BREAKFAST SAUSAGE	1310 30	HAMBURGER	1460 10
BEEF	1110 10	PORK AND BACON SAUSAGE	1310 50	CHOPPED BEEF	1460 30
BEEF TONGUES	1110 30	MISCELLANEOUS	1310 90	MISCELLANEOUS	1460 90
MISCELLANEOUS	1110 90	SAUSAGE DRIED OR SEMI-DRIED		CANNED PRODUCT	
PORK SMOKED AND/OR DRIED		SALAMI	1320 10	LUNCHEON MEAT	2610 10
HAMS	REGULAR 1120 11	CERVELAT	1320 30	CANNED HAMS	2620 20
	COOKED 1120 12	PEPPERONI	1320 50	BEEF HASH	2630 30
PICNICS	REGULAR 1120 21	THURINGER	1320 70	VIENNAS	REGULAR 2650 41
	COOKED 1120 22	MISCELLANEOUS	1320 90		CEREAL 2650 43
SHOULDERS	REGULAR 1120 31	SAUSAGE SMOKED OR COOKED		NFD MILK	2650 44
	COOKED 1120 32			REGULAR 2660 51	
PORK LOINS	REGULAR 1120 41	FRANKS AND WIENERS	REGULAR 1330 11	FRANKS AND WIENERS	CEREAL 2660 53
	CEREAL 1330 13		NFD MILK 2660 54		
PORK BUTTS	REGULAR 1120 51	BOLOGNA	NFD MILK 1330 14	DEVILED HAM	2670 60
	REGULAR 1120 52		REGULAR 1340 11		CHOPPED BEEF
BACON	1120 60		CEREAL 1340 13	SAUSAGE	REGULAR 2770 81
	REGULAR 1120 91		NFD MILK 1340 14		CEREAL 2770 83
MISCEL-LANEOUS	COOKED 1120 92	LIVER SAUSAGE	REGULAR 1340 31	CANNED LOINS & PICNICS	2770 84
			CEREAL 1340 33		NFD MILK 2840 90
		SMOKED PORK SAUSAGE	NFD MILK 1340 34		
			1340 40		

Example #2

MEAT AND MEAT FOOD PRODUCTS

Product	Code	Jul	Aug	Sept	Oct	Nov	Dec	Jan	Feb	Mar	Apr	May	June
All Meat Bologna	1340 11					1 6 8 2 7 9C 3B 10 4C 11 (5)		12 13					
Bologna - Cereal Added	1340 13					1 3 2		4					
Franks - All Beef	1330 11					1 2							
Franks - All Meat	1330 11					1 2 3 4							
Franks - NFDM Added	1330 14					1 2 3		4 5					
Franks - Cereal Added	1330 13					1 2		3					
Pork Sausage	1310 10					1 2 3 (2) 3 (8) 7 8	(4) 3 (6) 7 8	9 10					
Hamburger	1460 10					1 2							
Chili - No Beans						1 2							
Chile with Beans						1 2							
Luncheon Loaf						1							
Liver Sausage - NFDM Added	1340 34					1							
Braunschweiger	1340 31						1						
Tastee Loaf							1						
Xout Loaf								1					
Sure Fire Loaf								1					
BBQ Loaf						1							
Chopped Ham							1						

Example #3

NONMEAT ITEMS

Product	Jul	Aug	Sept	Oct	Nov	Dec	Jan	Feb	Mar	Apr	May	June
Nonfat Dry Milk Dairy Farm Gilroy Creamery					1 2	7	11 13 12 10					
Gelatin Grays Lake Co.					3							
Soap - Hand Oakite No. 188					5							
Salt						8						
Seasoning Frank Griffith Kearnsmith Kadison					4	6 9		14				

B. When using Form MI-422 (snap-out type), inspectors should place it on a hard even surface and make the entries in such a manner that they will be legible on all copies. Do not remove carbons from the form before sending it to the laboratory. Items 6 and 7 on the form will be completed by the laboratory so should not be used by the inspector. Distribution instructions printed at the bottom of the form should be followed.

C. All sample forms for products should include the inspector's request for information concerning the product represented by the sample. He may indicate the information desired by placing a check mark, or check marks, in the column to the left opposite the appropriate items listed; for example, "added water," "N.F.D. milk," "Cereal." If an item requested is not listed under No. 8, the check mark should be placed to the left of "Other" and the specific request written in the space provided. Unless a sample is accompanied by a form asking for specific information, the sample will be discarded by the laboratory. The laboratory will return the form to the inspector with a notation to that effect.

D. When a sample does not comply with the Regulations, the inspector should state the corrective action taken on the original and first copies in accordance with the instructions on the reverse side of the form. This report should be forwarded to the Officer in Charge for his comments and signature and then sent to the District Director. Be sure that the form sent to the District Director is legible and shows the action taken for correction of the reported violation.

318.72

A. When a sample is sent to the Meat Inspection Laboratory for special purpose, a notation must be made on the laboratory form to that effect or the form should bear reference to a letter or correspondence. If no notation appears on the form to indicate special handling, the sample may be discarded or given the usual analysis for the class of product, especially if it arrives ahead of any correspondence on the subject.

B. Samples submitted at the request of the Labels, Standards and Packaging Branch or involved with questions handled by that office (unless these are instructions to the contrary) should be directed to the Labels, Standards and Packaging Branch, Technical Services Division, Consumer and Marketing Service, U. S. Department of Agriculture, Washington, D.C. 20250. Perishable products should be appropriately handled.

318.73 Fiber cartons for forwarding samples are stocked at the following stations: Chicago, Illinois; Kansas City, Kansas; New York, New York; St. Louis, Missouri; San Francisco, California; and Washington, D. C. The fiber cartons should be used exclusively for sending samples to the laboratory.

Where fewer than three samples are placed in the carton, the additional space should be filled with paper or other light waste material. Two addressed franks, one for forwarding samples to the proper laboratory from which they were forwarded, should be prepared by the inspector at the establishment. The franks should be placed on the carton in such a way that only the outgoing frank will be visible when the carton is tied and ready for mailing. In this way, an adequate supply of sample containers and cartons should be available at the establishment whenever needed.

318.74 The following instructions apply to the control of canned pork products, cooked cured pork products and smoked pork products:

A. Inspector's Responsibilities. The inspector has the responsibility, as with all other products, to ascertain that the smoked, cooked and canned hams and other cured pork items distributed from the establishment are in compliance with the Regulations. In order to fulfill this responsibility the inspector must have sufficient knowledge of the establishment's production practices and control procedures to evaluate their effects on the finished product.

The inspector is required to know, by frequent direct observation of the measuring and weighing of restricted ingredients, the exact amount of these ingredients used in curing solutions. Information gained from establishment personnel alone is not sufficient. Samples of curing solutions collected at irregular intervals should be submitted for laboratory analysis. Any significant deviation in nitrite, phosphate, or ascorbate content between pickle made under direct supervision and that formulated without supervision would indicate a need for closer supervision by the establishment management and more restrictive control by the inspector.

In order to assure that restricted ingredients are not being used in excess of the quantity permitted by the Regulations and that the pumping procedure is uniform, the inspector is required to conduct calculations to determine the percentage of curing solution injected into each kind of product.

B. Establishment Responsibilities. The establishment is expected to exercise control over all restricted ingredients and the curing, smoking and chilling practices to assure continued production of products in compliance with the Regulations. The establishment is expected to adopt uniform procedures for pumping, curing, smoking and chilling each kind of product to prevent unusual product variation. In the curing of hams and picnics, it is important that the pumping procedure be closely controlled by the establishment.

C. Procedure Chart. The ability of the inspector to insure establishment control of the product is dependent upon his thorough knowledge of plant procedures. The following chart (or a local modification) is suggested as being helpful in this respect.

This chart in conjunction with those outlined for use with the 30/30 test, shrink test, and laboratory analysis (identified as Records 1, 2, & 3), will provide opportunity for inspectors to evaluate the ability of a specific procedure to produce products in compliance with analytical requirements and to confer with establishment personnel on any procedural change required for added moisture adjustment. In the event the establishment alters procedures by changing pickle formulation and/or pumping percentage and/or smoke-house or cooler shrinkage, a new processing procedure chart must be made to reflect the change. Supervisory personnel should conduct weekly reviews of establishment procedures for curing, pumping, smoking and chilling to determine the accuracy of current charts for each product.

Est. 38 Procedure Chart

Product Name _____ Wt. Range _____
 Date _____ Est. Off. Signature _____

PICKLE FORMULA:

	PUMP	COVER
Total Gallons	_____	_____
Salometer	_____o	_____o
Salt (lbs.)	_____	_____
Sugar (Dextrose)	_____	_____
Corn Syrup (lbs.)	_____	_____
Phosphate "	_____	_____
Ascorbate "	_____	_____
Nitrate "	_____	_____
Nitrite "	_____	_____

CURE CYCLE:

Percent pump _____
 Drain time _____
 Time in C. Pickle _____

SMOKE CYCLE:

Time in smoke _____
 Percent humidity _____
 Temperature _____

COOLER CYCLE:

Time held _____

D. Thirty-Thirty Test. The 30/30 test offers the establishment and the inspector one method of confirming the accuracy of the pumping portion of the overall curing process. This test shall be used unless different methods of process review are offered by the establishment, and such methods have the approval of the Officer in Charge. In employing the 30/30 test:

1. The establishment shall:

- a. Lot hams and picnics in two pound weight ranges. Since the test cannot be run on product not lotted in this manner, alternate methods of lotting will not be allowed.
- b. Provide the inspector with copies of all processing procedures for each class of product. (Example of a procedure chart follows, adaptations of the chart for local needs may be made.) This chart shall be kept on file in the government office. The Officer in Charge should get copies of these charts.
- c. Identify each lot of fresh hams and picnics by weight range and intended purpose (e.g., cooking, canning, water added, smoking, etc.,) prior to pumping.

- d. Furnish all necessary assistance to the inspector, in order that the tests be run rapidly and accurately.
- e. Mark metal trucks and other containers used for weighing product with an accurate tare weight.
- f. Provide conveniently located accurate scales, lighting, tables, and such other facilities as are necessary to conduct the tests.

2. The inspector shall:

- a. Test only product that is lotted in two pound weight ranges.
- b. Apply the procedure to all cured hams and picnics that are to be smoked, cooked or canned.
- c. Run enough tests each day at unannounced intervals to insure plant conformity to listed processes.
- d. Follow the prescribed procedure in exactly the order given. The procedure is to:
 - (1) Randomly select 30 pumped hams from one production lot, and have them accurately weighed by a plant employee under his supervision. This should be done after a 30 minute drain, or the weight adjusted for an average drain.
 - (2) Randomly select 30 fresh hams from the same production lot prior to pumping and have them accurately weighed by a plant employee under his supervision.
 - (3) Determine the percent gain of A over B.
 - (4) Record this information on a uniform chart. (A suggested example which may be adapted to local needs follows.) This shall be filed in the government office.
 - (5) Determine compliance by comparing percent gain found with percent gain listed on procedure chart.
- e. Take the following action when percent gain is more than 3 percent over or under the listed process:
 - (1) Inform plant management immediately to determine cause and make necessary correction.
 - (2) If product is overpumped, retain until drained to proper percent gain, or

- (3) Treat as untried new process and retain product, pending laboratory analysis.

A suggested chart for maintaining curing checks follows:

Est. 38 Smoked Meats Record Sheet

Record 1 - for curing checks

Test Date & Lot No.	Bone-in Green Wt.	Boneless or Semi-boneless Green Wt. (X)	Pumped Weight	Cover Pickle Exit Wt. (Z)	Percent Yield

(X)omit this column for all product finished bone-in.
(Z)omit this column for product not put in cover pickle.

E. Shrink Tests. As part of in-plant controls, the inspector is required to have knowledge of the usual shrinkage of each kind of product during the smoking process. This information should be related to time, temperature and relative humidity. The usual percentage of shrinkage during various chilling periods for each kind of product must also be established by the inspector. In developing the information, it is essential that the inspectors use their knowledge of packinghouse procedures and variation in facilities. (A suggested record chart for this information follows. The chart may be adapted for local needs.)

Record 2 - Shrink tests for (A) Smokehouse, or (B) Cooler

Test Date & Lot No.	Designate if for (A) or (B)	Entrance Weight	Exit Weight	Percent Yield

F. Laboratory Analyses. Ultimately the ability of a process to produce product in compliance, and the acceptability of the end product itself is based upon laboratory analysis. Essentially, this procedure is based upon recording and interpreting the results obtained for percent protein, water, and salt in samples of the finished product. These results are converted to yield figures for each product by use of the following table and formula:

PROTEIN MULTIPLIER (K)

Smoked Hams	3.79
Smoked Picnics, Smoked Butts (and Misc. Products)	4.00
Canned Picnics	3.93
Canned Hams, Loins and Canned Pork Products	3.83

Estimated Yield = Moisture + Salt - K Protein + 100

Analytical results, dates of sampling, product examined, and added substance may be recorded in a manner similar to the following chart. Any action taken by the inspector to reduce added substances content or to retain product pending laboratory analysis should be noted on the chart.

Record 3 - Laboratory Results

Sample Date	Sample Number	Water or Substance (±)	Remarks	Inspector's Initials

1. Sampling for Laboratory Analysis:

- a. Selection of samples. The importance of collecting a random sample cannot be overemphasized. It must be done intelligently, always bearing in mind the time of sampling, location where selected, weight average of the product, and any other factor that could be anticipated. The inspector must maintain security of the sample from the time it is first selected until it is in custody of the Post Office Department.

To assure that samples submitted for analysis are representative of production, samples of the same class of smoked, cured or canned pork products will be collected during the day and/or night when they are to be submitted for laboratory analysis.
- b. Number of samples. Submit samples as often as necessary, based on the specific operating practices at the establishment, amount of production, history of compliance and variations in sample results. The District Office will authorize Officers in Charge to conduct market sampling of product when such information is considered necessary to determine the acceptability of procedures used by the establishment.

c. Sampling cured product received for further processing. Establishments receiving cured products for further processing will need to establish a history indicating acceptability of the processing procedures and inspectors will sample each lot of product until such information is developed. If cured products for further processing are received from several establishments, a history as outlined above must be developed for each curing establishment from which products are received.

d. Providing duplicate samples for the establishment. Some establishments may wish to obtain a duplicate of the sample submitted by the inspector to the Meat Inspection Laboratory. This is permissible when a truly representative sample is provided. The following facilities and procedures will be used in the preparation of samples in this regard:

e. Preparation of samples.

(1) A power-driven grinder with C-12 chopper ends, plate with 1/8 inch openings, two pans large enough to permit boning of the product and mixing of the chopped material, and knives suitable for boning and trimming. If C-12 chopper ends are not available, a large chopper may be used provided it is dismantled and that portion of the product remaining in the barrel and screw is removed and included with the sample.

(2) All operations must be conducted as quickly as possible to minimize moisture loss by evaporation. The product should not be placed on absorbent material or unnecessarily exposed to evaporation either before or after chopping. All liquid which escapes during boning, cutting or trimming must be reincorporated during the chopping and mixing operation. Failure to follow these instructions closely will result in the sample not being representative of the product.

(3) Boning, cutting and trimming of the ham or other pork cut should be performed over a pan to prevent loss of liquid which escapes. The bone should be trimmed free of meat insofar as practicable and the trimmings and all fat from the individual piece should be included with the sample. All material except the bone and skin should be passed rapidly through the chopper twice and mixed thoroughly after each chopping. Approximately one pound of the ground, mixed meat should be placed immediately in an impervious plastic bag that must be tightly closed to prevent loss of moisture; samples of one and one-half pounds are desirable.

(4) When a whole bone-in unit is submitted, any protruding bone should be removed and/or several layers of nonabsorbent material should be securely fixed over the area of the bone to prevent puncture of the sample bag.

f. Sample unit. A production unit is a whole ham or a pork shoulder picnic, etc. A laboratory sample may be the whole unit; a ground portion taken from a production unit and prepared as described; or a center slice one-inch thick taken from a ham, pork shoulder picnic, or similar product. A sample of a cured canned product shall consist of one unopened can. A sample of sliced packaged product should consist of at least three one-pound packages, preferably taken from the same unit.

Products labeled "Sliced Cooked Ham, Gelatin Added" derived from canned ham identified as "Cooked Ham, With Natural Juices, Gelatin Added." In preparing canned hams for slicing after their removal from cans, the free juices and surface gelatin are discarded when the sliced product is sampled. A notation should be made on Form MI-422 to indicate that the product was derived from a canned ham and that the surface gelatin and free juices were removed. This will inform the Meat Inspection Laboratory that no adjustment for gelatin is necessary.

g. Submission of samples. The mailing of samples to the laboratories should be accomplished so that the sample does not arrive at the laboratory on Saturday, Sunday, or holidays. Samples obtained toward the end of the week may be held under seal at the establishment pending proper mailing time. Extreme care should be exercised in preparing, packaging and mailing samples to the laboratory. When plastic sample containers are broken, torn or otherwise perforated, the sample is useless to the laboratory for analytical work.

h. Sampling for nitrites. No determination of nitrite will be made by the laboratories on chopped samples unless they are received in the laboratory the same day as collected, or are packed in sufficient quantity of dry ice or similarly protected to prevent changes in nitrite content.

2. Smoked and Cooked Cured Pork Products: The laboratory will report percentages of added substances or added water without reference to compliance or lack of compliance of the product.

The following criteria are to be used in evaluating the analytical returns for added substance in smoked pork products and cooked canned products. Use of these criteria recognizes differences resulting from analytical variance and practical sampling limitations and assures substantial compliance. For the present time, cooked cured pork products will be included in the general range of miscellaneous products.

- a. Each single sample is expected to be within the upper limits identified in Table I-A for that product.
- b. Single sample returns that are higher than the upper limits in Table I-A but within the limits identified in Table I-B indicate a need for immediate change in processing procedure and corrective action sufficient to bring future single samples within the expected range. This corrective action can be accomplished by altering the curing procedures, increasing smoking time or increasing processing temperature to effect necessary results.
- c. When single sample results are higher than those provided for in Table I-B, all product of the type represented by the sample should be retained. Processing procedures must be altered to effect corrective action. No lot of product represented by this sample would be released until further processed or handled in a manner to bring the product into compliance.
- d. In addition to the above action for single sample results, the average of the last five single sample results is expected to be within the upper limits outlined in Table II-A for that type of product. As long as the average of the last five results does not exceed this requirement and the return on any individual sample does not exceed the upper limits outlined in Table I-A, the product may move freely.
- e. If the average of the last five samples is more than that permitted in Table II-A, but within that allowed in Table II-B for that type of product, and the establishment has a satisfactory history of compliance for that type of product, corrective action as in paragraph 2 b is indicated.
- f. If the average of laboratory sample results is above that provided for in Table II-B, corrective action will be taken as outlined in paragraph 2 c. After sufficient samples have been taken to return the running average of the last five samples to within the upper limits provided for in Table II-A for that type of product, then procedures can return to normal.

RANGES FOR SINGLE SAMPLE RETURNS

TABLE I-A

Smoked Hams	<u>+5.8</u>
Smoked Picnics	<u>+4.5</u>
Smoked Butts	
(and Misc. Products)	<u>+4.5</u>

TABLE I-B

Smoked Hams	+5.9 to 7.4
Smoked Picnics	4.6 to 5.8
Smoked Butts	
(and Misc. Products)	4.6 to 5.8

RANGES FOR AVERAGE OF RETURNS

TABLE II-A

Smoked Hams	<u>+2.6</u>
Smoked Picnics	<u>+2.0</u>
Smoked Butts	
(and Misc. Products)	<u>+2.0</u>

TABLE II-B

Smoked Hams	2.7 to 3.3
Smoked Picnics	2.1 to 2.6
Smoked Butts	
(and Misc. Products)	2.1 to 2.5

The rate of production should be fairly constant during the sampling pattern; that is, if production should increase materially, more samples should be taken in proportion to the increased production. The laboratory results of product prepared under one processing procedure must not be averaged with product prepared under a different procedure. In calculating the running average, the limit on negative results will be that defined in Table I-A for that type of product.

This section provides for differences resulting from analytical variance and practical sampling limitations only and should not be construed as a deviation from the requirements of the Meat Inspection Regulations.

From time to time inspectors should conduct yield tests at the establishment for different smoked and cured pork products to determine if the laboratory sampling controls are effective in the production of proper product. However, the decision on corrective action to be taken against product will continue to be applied on the basis of laboratory returns and the results of a continuing average of results falling within approved range for these products as outlined.

When as a result of all information available including analysis of samples the inspector determines that the processing procedures are not producing product in compliance with the Regulations, the inspector will retain product for such additional processing as needed and require corrective measures in the processing until he is assured that the class of product measures in the distribution is in compliance with the Regulations. Any unproven change in processing procedure would be the basis for retention until sufficient returns are available to indicate compliance unless the changes made by the industry in the processing procedures would appear to result in product that would be in compliance.

3. Domestic Canned Pork Products: Laboratory results for added substances for canned hams should fall within the following zones when they originate from a lot of product that has been processed in compliance with the Regulations.

Zone for control purposes, into which laboratory results for added substances should fall:

	<u>Canned Hams</u>	<u>Canned Picnics</u>
Upper Control Limit	116.3 and above	113.6 and above
Zone A	113.6 to 116.2	111.7 to 113.5
Zone B	110.9 to 113.5	109.9 to 111.6
Zone C	108.1 to 110.8	108.1 to 109.8
Zone C'	105.2 to 108.0	106.2 to 108.0
Zone B'	102.5 to 105.1	104.4 to 106.1
Zone A'	99.8 to 102.4	102.4 to 104.3
Lower Control Limit	99.7 and below	102.4 and below

The control of added substances in canned loins and other pork products may be accomplished by using the general instructions for canned hams; or at the discretion of the establishment, by using in-plant inspectional controls.

The analytical control procedure requires that the inspector:

- a. Draws random samples of the product and sends them to the designated laboratory for a report on estimated yield. The accuracy of determining added substances is enhanced when the amount of added gelatin is known. The amount of added gelatin shall be shown on Form MI-422 when product is sent to the laboratory. The gelatin should be added by weight, measure or otherwise meter in a manner to insure a standard portion in each unit.
- b. Maintain separate control charts for canned hams, picnics and loins. When one product (e.g. canned ham) is produced by more than one process, separate charts must be kept for each process. Show the full name of the product on the heading of the chart.
- c. Plot each laboratory yield analysis result on the applicable chart (see Exhibits A and B).
- d. Date all entries made on the chart.
- e. Examine the chart after posting each analytical yield result to determine whether the process is in control. The process may be considered in control until such time as:
 - (1) Eight consecutive samples fall in Zone C or higher.
 - (2) Four out of five consecutive samples fall in Zone B or higher.
 - (3) Two out of three consecutive samples fall in Zone A.

(4) Any sample equals or exceeds the Upper Control Limit.

f. Inform PMID, Planning Branch, Procedures and Standards Office of all instances where samples are plus or minus three zones from the proceeding sample, and this variation takes place over four or more consecutive samples. Any other seemingly unusual fluctuations should be reported.

g. Take the following action related to analytical results:

(1) Allow the product to move without interruption as long as the process is in control.

(2) Retain all product pending satisfactory laboratory analysis when such product is the result of a process which is out of control. For the purpose of releasing retained product only, a satisfactory laboratory analysis is one that has an estimated yield of 108.0 percent or lower, or is in Zone C, but at least one of the previous seven samples was in C' Zone or lower. Lots with an unsatisfactory analysis must be relabeled or the cans opened and the product reworked.

(3) Advise the plant that a significant change in process is necessary when the chart shows that the process has gone out of control. As a means of determining the change needed, the average of those samples causing the process to go out of control should be obtained. This average minus 108.0 percent is an indication of the adjustment needed to bring the process back into control.

(4) Start a new chart if a process goes out of control and the establishment makes a significant change in process. He will not retain product while he:

(a) Assures himself that the establishment follows new process.

(b) Increases sampling rates to every day or every other day in order to build a fast history on the adequacy of the new process.

(c) Maintains the increased sampling rate until the chart, on the basis of the first eight samples, indicates that the process is in control, or until such time as the new process is shown to be out of control.

(5) Maintain the same chart, and retain and analyze all subsequent lots when a process goes out of control and no change or an insignificant change is made in the

process by the establishment. Judgment as to whether to pass or reject the lot will be based on the criteria listed in paragraph g (2) above for satisfactory laboratory analysis. The procedure shall continue until analyses of eight consecutive samples indicate the process is again in control.

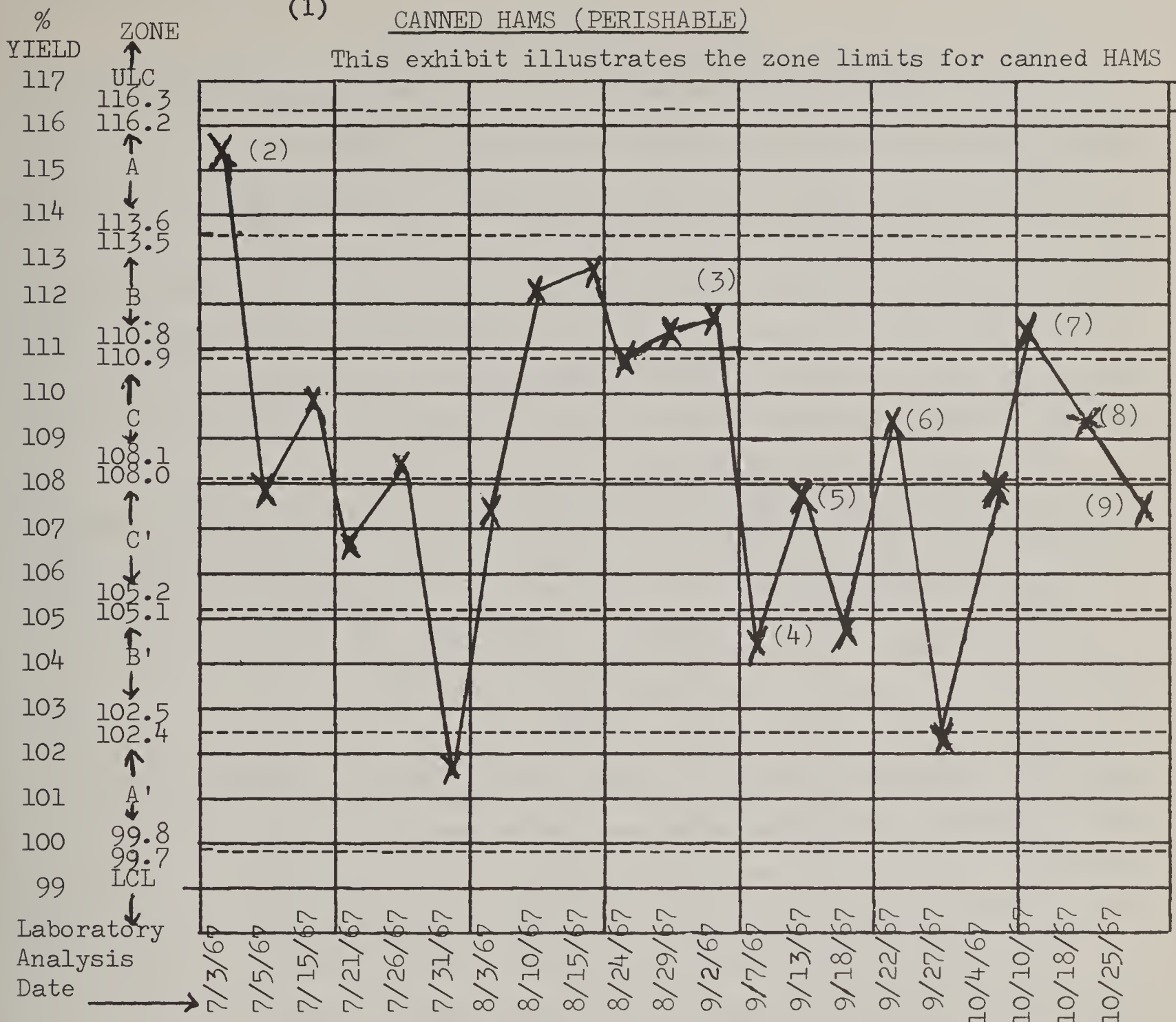
(6) Not permit changes in processes tending to give higher yields unless the process goes out of control in the low yield zones. The process will not be out of control in these areas until:

- (a) Eight consecutive samples fall in Zone C' or lower.
- (b) Four out of five consecutive samples fall in Zone B' or lower.
- (c) Two out of three consecutive samples fall in Zone A'.
- (d) Any sample falls under the Lower Control Limit.
- (e) Any unauthorized changes in process increasing the yield of product before the above limits are reached will call for procedures outlined above, except that the product will be retained pending laboratory analysis. This procedure will continue until the process is proven to be in control over eight consecutive samples.

(1)

CANNED HAMS (PERISHABLE)

This exhibit illustrates the zone limits for canned HAMS



(1) Enter full name of product.

(2) Show date of each laboratory yield analysis, and plot result with an "X".

(3) At this point, process has gone out of control because 4 out of 5 latest analyses are in B Zone. The average of these 5 samples is 111.75 and therefore a 3.75% reduction in yield is indicated. If the packer will not change his process, all lots are retained pending satisfactory laboratory analysis.

(4) While process is out of control, plot results in red.

(5) Satisfactory analysis; less than 108%.

(6) Satisfactory analysis; sample in C Zone but at least 1 of previous 7 was in C' Zone or lower.

(7) Unsatisfactory; no sample allowed in B range or higher while process is identified as being out of control. Product must be relabeled.

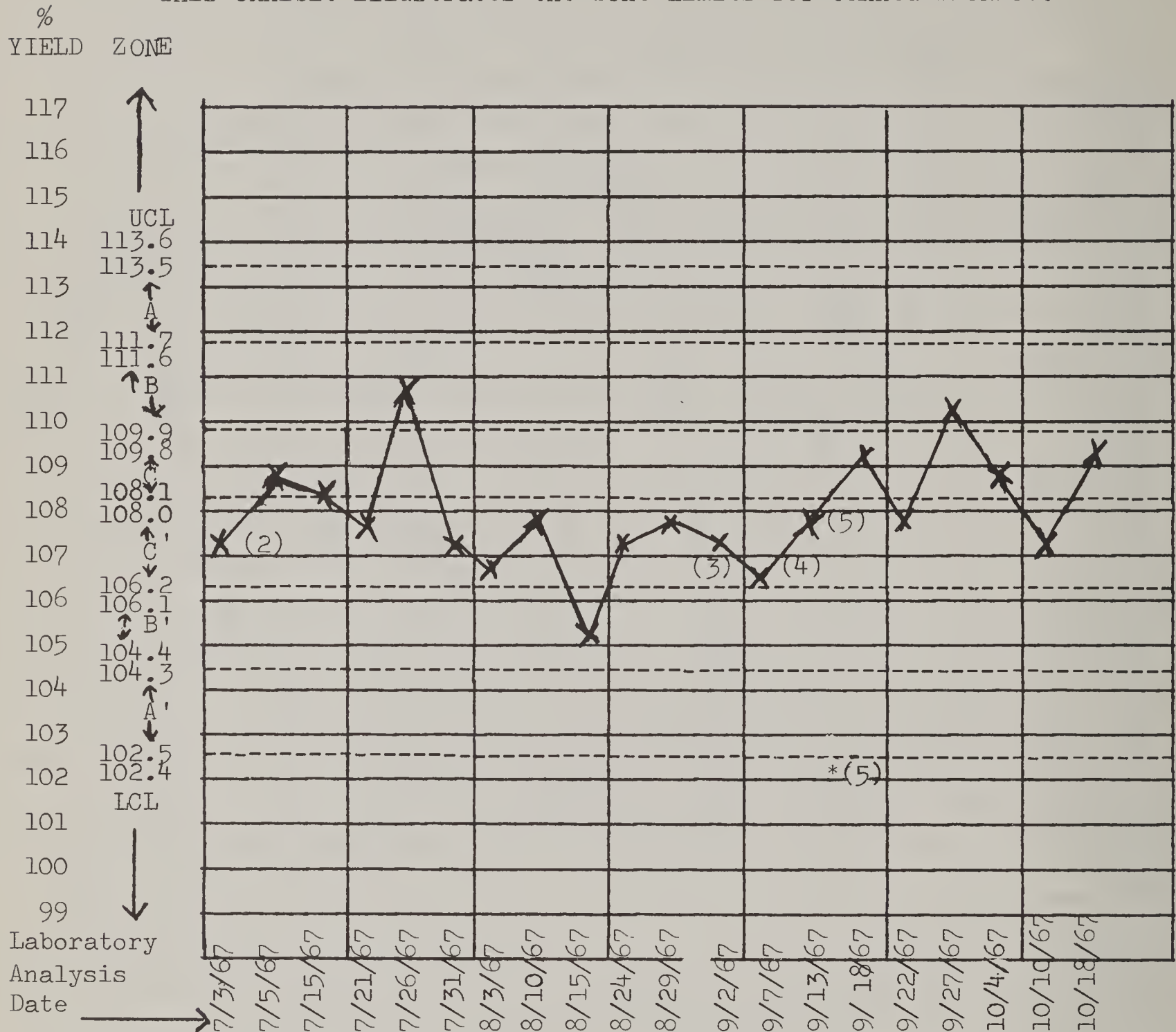
(8) Process now back in control over 8 samples.

(9) Product represented may move freely.

(10) Ignore (4) to (a) if packer makes indicated change in process and start a new chart.

(1) CANNED PICNICS (PERISHABLE)

This exhibit illustrates the zone limits for canned PICNICS.



(1) Enter full name of product.

(2) Show date of each laboratory yield analysis and plot result with an "X".

(3) Results to this point illustrate a process in control on the low yield side. Should the process be changed to increase the yield, start a new chart, and retain lots pending satisfactory laboratory analysis until the process is proven in control over 8 samples drawn daily or every other day.

(4) At this point, the process is out of control on the low side and may be changed to give an increased yield. The indicated increase would be the average of the 8 samples causing the process to go out of control (106.9) subtracted from 108, or a change of 1.1. Continue plotting on the same chart. Allow product to move freely.

(5) If process is changed as in (4), make note on chart. Maintain record of new procedure.

*(5) See attached sheet for revised procedure.

G. General. There are certain phrases and terms in connection with the control procedures which may need further clarification:

1. "Products of the class" means a specific kind of product; for example, "Regular, Bone-in Smoked," "Regular Bone-in Shankless Smoked Ham," "Fully Cooked Regular Bone-in Smoked Ham," or "Fully Cooked Boneless Ham."

2. "Product on hand represented by the sample" means that the kind of product produced by the same procedures as the sample regardless of weight range or date of production.

3. "Brought into compliance" refers to reducing added substances to within the acceptable range as outlined in Interpretation of Analytical Results.

318.75 The water-protein ratio in canned luncheon meats and potted meat food products varies depending on the percent of tripe, tongues, or hearts in the formula. Therefore, when samples of luncheon meat and potted meat food products are submitted for laboratory analysis, the inspector must record on Form MI-422 the percentage of tongues and hearts in the formula for luncheon meat and the percentage of tripe in potted meat food products.

318.76

A. Inspectors are sometimes required to make a considerable number of inspections of materials other than meat or meat food products that are used in preparation of products and otherwise in official establishments.

In order to evaluate the requirements for this important phase of the inspection work more accurately, Form MI-407-4 has been designed for use in reporting rejection of materials found to be unacceptable for use.

One form should be used for each material rejected, and one completed form should be sent to the C&MS Meat Inspection Administrative Staff, Chicago, Illinois, along with other MI reports, and one copy retained for Circuit files. When there is no rejection at the station during a calendar month, a report should be completed with the notation, "There were no materials rejected at this station during the month of ____."

B. Materials other than products that have been rejected for use may be removed from the establishment or destroyed within the establishment if the management so desires. In most instances, it will be well to notify the Food and Drug Administration and local health authorities of such action.

318.77 Powdered, semisolid, viscous, or fluid soup bases, gravy mixes, dehydrated soup mixes, bouillon cubes, and the like, containing meat extract or animal fats or both as the only meat or meat byproduct ingredient, will not be regarded as meat food products. When such articles are prepared for sale in interstate or foreign commerce or are offered for importation into the United States or its territories, they are subject to the Food, Drug, and Cosmetic Act administered by the Food and Drug Administration of the Department of Health, Education, and Welfare.

318.78 The inspection procedures contained in this Manual provide adequate tools to obtain the production of meat food products in compliance with the Meat Inspection Regulations if properly applied by the assigned inspector. This is demonstrated by the fact that practically all establishments routinely produce product in compliance under these inspection procedures.

However, some inspectors incorrectly consider the existence of a record of having applied the inspection procedures as the end of their responsibility in this area. A record of having applied the approved inspection procedures in an establishment is not by itself adequate evidence of an effective inspection program in that plant. An additional important evaluation of the effectiveness of the inspector's performance can be obtained by examination of the product the establishment is permitted to ship with the marks of Federal meat inspection.

It is quite apparent that the manner in which "in-plant" inspection procedures are applied is extremely important. First is the matter of security as it relates to the sample preparation and submittal procedure. An inspector selecting a sample must not leave it unattended before, during or after sample preparation. The selection of the sample must be done intelligently to reflect the type of product currently being produced by the establishment. Should the inspector fail to vary his sampling pattern intelligently or to properly select a random sample, the establishment could anticipate his inspection procedures and the sample results might be completely inaccurate as far as the total production is concerned. This is an area where an inspector's competence and ingenuity must be exercised to the fullest and he is completely responsible.

In addition to the usual methods of reviewing inspection, supervisors and Officers in Charge should frequently evaluate products produced at establishments by examining a number of units of a particular type of product taken from marketing channels. Under the guidance of the District Director, a program should be developed to check the product to be sampled and the components to be tested for—such as added substances, preservatives, etc.

The results of these market sample tests should closely parallel the results of the inspector's "in-plant" program. If the results of the market samples do not closely resemble the "in-plant" program, it demonstrates inadequate inspection, improperly applied inspection, or other inspection faults needing correction. In these cases, the Officer in Charge should promptly make such arrangements as he feels are necessary to correct the deficiency and at the same time continue to apply close supervision over the product leaving the establishment.

318.79 Products identified on the container, as follows, are being produced under Federal inspection.

- A. "Pork Cracklings, With Water Added."
- B. "Pork Crackling, With Beef Blood and Water Added."
- C. "Residue From the Rendering of Pork Fat, With Water Added."
- D. "Residue From the Rendering of Pork Fat, With Beef Blood and Water Added."
- E. "Beef Cracklings With Water Added."
- F. "Beef Cracklings With Beef Blood and Water Added."
- G. "Residue From the Rendering of Beef Fat, With Water Added."
- H. "Residue From the Rendering of Beef Fat, With Beef Blood and Water Added."

These products are prepared from edible ingredients and are adequately described by the label on the container. They have not been accepted as ingredients of any meat food product. The necessary inspectional control to prevent misuse of these products if they are handled at an establishment must be provided.

318.80 Inspectors must be alert to detect and eliminate an unsound condition, improper weight, and adulteration of packaged meats and meat byproducts such as livers, hearts, tripe, kidneys, cheek meat, etc. This applied not only to products shipped in domestic commerce but particularly to products certified for export.

The following areas of inspection must be given special attention:

- A. Meat byproducts must be properly handled to prevent unsoundness. These types of products are particularly prone to unsoundness if not properly chilled or frozen. If the chilling and freezing operations are performed in the federally inspected establishment, they must be done in a manner that will result in completely sound material. Occasionally offal products are bulk packed before being chilled. Freezing in this case must be followed by further examination to detect any possible unsoundness.

B. Products must be properly drained prior to packing or for use as an ingredient in a manufactured meat food product. It has been demonstrated that improper draining of meat byproducts after washing or soaking in water can carry excess water into the package or into the manufactured meat food product. Inspectors must be alert to control these practices. Improperly drained product, particularly pork hearts, cheek meat, tripe, head meat, etc., can add considerable weight to the packaged product. This results in a deceptive weight of the package and is also important when these items are used as an ingredient of a meat food product having water limitations such as luncheon meat, potted meat food product, etc. The adulterated ingredients become a means of introducing additional water to the end product. Products should be well drained after immersion in water.

C. In the certification of meat byproducts for export, inspectors must be alert to ascertain that only sound, wholesome, product is being certified. Many times packaged product may leave inspected establishments and after varying periods in outside storage is presented for export certification. In these cases, the inspector must be particularly careful to assure himself the product has not been mishandled in the meantime and is still completely sound and wholesome. In frozen product this may be done by defrosting samples or removing frozen cores of product for defrosting and examination. The amount and kind of reinspection required will depend upon the circumstances and knowledge the inspector has concerning the prior handling of the product.

Inspectors will be held strictly responsible for all products certified by them. Furthermore, supervisors and Officers in Charge who are responsible for these inspections at their Circuits must arrange to review the efficiency of inspectors' decisions at regular intervals.

318.81 Pizza pie crust or dough, masa, tortillas, and similar bakery items used in preparing meat food products in official establishments must be prepared either in an official establishment, under the supervision of the Processed Products Standardization and Inspection Branch, Fruit and Vegetable Division, C&MS, and so certified, or received from an approved supplier.

An approved supplier is a manufacturer known to be operating under acceptable sanitary conditions and in a position to certify the formula and ingredients used in each shipment. The official establishment receiving the prepared article from an approved supplier must arrange for unqualified entry of our inspector into the facilities where the article is prepared. At the discretion of the Officer in Charge, our inspector in the area where the nonmeat item is produced will make occasional reviews of the operations to check the formulation and assure sanitary handling of the component intended to be used in the manufacture of an inspected product.

318.82 Anticaking agents. We currently accept salt, cures or seasonings containing up to 2 percent singly or in combination of tricalcium phosphate, tetrasodium pyrophosphate, calcium carbonate, magnesium carbonate, calcium stearate, silica gel, calcium aluminum silicate, calcium silicate, magnesium silicate, sodium alumino-silicate, sodium calcium alumino-silicate, sorbitol, glycerol (glycerin) or propylene glycol as anticaking agents.

The label on the container of such preparation must reflect the presence of these agents.

We also accept salt containing up to 13 ppm of yellow prussiate of soda (sodium ferrocyanide decahydrate) as an anticaking agent. The label on the container may reflect its presence by a statement such as "Yellow Prussiate of Soda Added."

Our permission does not cover use of these agents as such in meat food products. When salt, seasoning or curing mixtures containing these are used in product, their presence need not be shown on the product label.

318.83 When commercial curing compounds containing nitrites are received, they may be released for use in the official establishment only if the manufacturer has indicated on the container that a sample of the lot from which this compound was derived was chemically analyzed and found to be acceptable and within the nitrite limitations on the label.

This additional control does not change the traditional sampling applied by the inspector to assure acceptability of the curing compound. In order to fully exercise his responsibilities, the inspector must periodically submit to the Meat Inspection Laboratory samples of shipments of curing compounds even though certified as described above.

318.84 Thermometers designed to register high and low temperature ranges are available to Meat Inspection Circuits for checking the accuracy of the working thermometer used by the inspector.

The thermometers are of two types:

- A. High-registers temperatures between 0 - 230 degrees F.
- B. Low-registers temperatures between -30 - +120 degrees F.

Each thermometer is identified with a number. The thermometer must be checked with the correction sheet available at the Circuit. To provide an available reference to the user, the corrective factor should be transferred from the sheet to a tag attached to the thermometer. To arrive at an accurate reading, a plus or minus degree, when shown on the correction sheet, must be added or subtracted from the reading on the thermometer.

The proper manner for testing the working thermometer with the standard check thermometer is as follows: High - place both the standard check for thermometer and the working thermometer in a mixed water solution at the temperature range you desire to check. In the case of the low thermometer, place the standard check thermometer in the cooler or freezer along with the working thermometer and leave for a period of time necessary to determine recorded temperature on both thermometers.

318.85 The preparation of loaves, other than those identified as meat loaves, generally involves the use of byproducts from processing operations including cured and uncured product.

Accordingly, trimmings derived during the preparation of pork cuts which have been cured with approved phosphates in addition to other curing ingredients may be used without limitation in the preparation of loaves (other than those designated as meat loaves). When used, the kind of phosphate should be shown in the statement of ingredients.

318.86 A problem exists when material has been found to be satisfactory chemically but proves to be unsatisfactory when put into actual use. This has been particularly true with solvents and plasticizers used with packaging material.

The usual procedure is for the manufacturer to submit the material to the Laboratory Branch of the Technical Services Division for approval. If they find the material to be chemically safe and it appears to be satisfactory, the manufacturer is notified by letter. The inspector at the establishment will permit the use of the material on the basis of this letter or he will submit a sample of the material to the local laboratory for approval. In either case, if approval is granted, it is with the understanding that the material proves to be acceptable in actual use. If the material disintegrates, has an appreciable odor, transfers color to the product or results in any other objectionable condition, it is not acceptable even though the original material has been approved by the laboratory. In many cases, this can only be determined by the inspector in the establishment.

Therefore, it is the responsibility of the inspector to make the final decision on the acceptability of material used in establishments under his supervision. If material that has been determined to be acceptable chemically proves to be unsatisfactory when used, the Laboratory Branch, Technical Services Division, should be notified.

318.87 Standard weight sets are available at each large Circuit. The District Director's office will inform Circuits where the sets will be located and how they will be made available.

It is the responsibility of the establishment and weights and measures officials to certify the accuracy of scales.

The inspector will use the test weights when he has reason to question or to check the adequacy of the establishment's scale testing program. This might involve checking old scales that quickly lose their accuracy to find out if the establishment is servicing the scales at frequent enough intervals. The program may include checking scales at intermittent intervals to insure the establishment's testing program is adequate. The check weights used by the establishment might be compared with our standard set. Particular attention should be given to the establishment's program for checking scales used in internal controls for regulatory requirements. This would include scales in spice rooms, formulating rooms, or scales used in determining gain during processing.

318.88 Smoked flavoring and imitation smoke flavoring. Initial lots of any of the preparations already determined to be acceptable or others which may subsequently be accepted should be sampled for laboratory analysis when presented for use in the plant. The preparation should not be used until a favorable report is received. In order to assure these items are as represented, we require that these come into official establishments unmixed with seasoning or curing materials. The plant may mix these with seasonings or cures prior to use after the inspector is sure the smoke flavor is satisfactory. If your office receives from a manufacturer or supplier requests for information as to how they may proceed to have a smoke flavoring cleared, you may refer them to the Laboratory Branch of the Technical Services Division.

It has also been decided to allow use of oil of cade to produce a simulated smoke flavor in certain products. It may be brought into the plant alone or in admixtures with acceptable seasoning materials and is subject to the same requirements as for imitation smoke flavor.

Smoke flavor or imitation smoke flavor should not be confused with some of those naturally smoked items which have been accepted by us in appropriate products in the past. These are smoked yeast, smoked cheese and smoked poultry which may be used as ingredients of certain meat products. There has been no change in respect to the use of these items.

Materials such as smoked salt, smoked soy flour, smoked nonfat dry milk, smoked seasonings, etc., prepared by direct exposure to wood smoke have not been approved. If proposed, these and other preparations which have been subject to smoke will be evaluated under the same criteria as used to determine the safety of the smoke flavor and imitation smoke flavor accepted previously.

318.89 Seafood in official establishments. The evisceration, scaling, cleaning or other similar preparation of seafood shall not be permitted in an official establishment unless the area in which such operations are conducted are completely separate from edible products department. Such areas must be approved for this purpose and be equipped with suitable and adequate sanitary facilities.

When clean, sound, wholesome seafood is cooked, canned, frozen or otherwise processed in an edible department of an official establishment, the operation must be separate from any meat processing operation. As far as practicable, these operations should be conducted in separate areas and using separate equipment. However, when equipment is used to process both meat and seafood, such equipment and the area in which it is operated must be thoroughly cleaned before being used to prepare meat products. Batters, breading mixtures, curing solutions and the like which contact seafood may not be used to prepare meat food products.

The storing of clean, sound, wholesome seafood and the handling as outlined above may be permitted in an official establishment provided the operation does not create a nuisance or interfere with inspection by reason of strong odor or otherwise.

318.90 The Regulations state that either fresh beef, cured beef or canned corned beef or a mixture of two or more of these ingredients may be used in the preparation of corned beef hash. Therefore, there are different ways of preparing product meeting the standard. Since the formulas used in these calculations depend on the nature of the meat ingredients used, it is essential that the inspector note on the laboratory form the source of the meat component.

If the analysis of one sample of hash known to have been made primarily from the cooked meat shows between 33 percent and 35 percent meat or that known to have been prepared from fresh meat shows 47 to 50 percent fresh meat, further samples should be taken to determine if the average will show 35 percent or 50 percent, respectively. Results on single sample of hash prepared from cooked meat showing less than 33 percent cooked meat or one prepared from fresh meat showing less than 47 percent fresh meat should be interpreted as representing product containing insufficient meat.

Although inspectional control is the principal basis for determining compliance with the Regulations, results of chemical analysis can be used to supplement this control. The results of analysis for fat and moisture are, of course, to be used as a basis for determining whether or not product is in compliance with respect to these components since limits on these are based on the finished product.

318.91 Fat for deep fat frying of products. The length of time fats and oils may be used for deep fat frying varies with the conditions of use. Particularly important are the frying temperature, the quantity of new fat added daily and the treatment of the fat during use.

Suitability of these fats for further use can be determined from the degree of foaming during use, the color, odor and flavor. Excessive foaming will probably be the first evidence of unsuitability. When the fat or oil foams over the side of the vessel during cooking, it should be discarded. The second most important evidence of unsuitability is darkened color. When the color becomes so dark that it is almost black as viewed through a colorless glass container, it should also be rejected. The inspector should, of course, continue to make the usual gross examinations and reject fat when the odor or flavor becomes objectionable.

The serviceable life of the fat can be extended by holding the temperature of the frying below 400 degrees F., replacing one-third or more of the fat daily, filtering the fat as needed and cleaning the system at least once a week. The addition of an antifoam agent such as methyl polysiloxane to the new fat is also helpful but is ineffective after foaming becomes a problem. It should not be added after the fat or oil foams over the side of the vessel during cooking.

318.92 Red Dye No. 4 is no longer a certified FD&C dye. Its use in meat products is not permitted in federally inspected plants.

318.93 Approved antioxidants may be added to fats prior to rendering. The amount of antioxidants allowed would be calculated on the basis of the anticipated yield of rendered fat.

In the processing of animal and vegetable fats at official establishments care must be taken to prevent the mixing of these components unless they have been properly mixed in the preparation of a combination animal and vegetable fat shortening.

The following control procedure shall apply:

A. There shall be a complete separation of the facilities for the receiving and holding of rendered animal fats from the facilities for receiving and holding of vegetable oils. There shall be no permanent connecting pipelines at any point in these preliminary handling operations.

B. Where pumps or lines are used in common, there must be an arrangement for disconnecting and cleaning the lines so there will be no possibility of interchange or mixing of the rendered fats and oils. For those establishments using a common hydrogenating, bleaching, filtering, deodorizing or filling line unit for both types of fats, care must be taken to prevent mixing of the animal and vegetable components (unless the fats have been properly mixed in the preparation of a combination animal fat-vegetable shortening).

Where the vegetable oils and animal fats are to be blended, the pipelines from each system shall end above the level of the contents in the blending tank.

C. Rework product. Both animal and vegetable shortening shall be used in animal-vegetable shortening unless other adequate control measures have been provided. All lines, receiving, holding and storage tanks, must be properly identified at all times.

The inspector will routinely sample incoming shipments of vegetable oils for the possible presence of animal fats. He will retain these samples pending results on finished product. He will take samples of the finished product throughout the day and identify these with the name of the product and code markings when applicable. These samples will be kept in a retaining compartment secured by a Meat Inspection seal. During the week, the inspector will select which finished product samples he will submit to the Meat Inspection Laboratory within the guidelines laid down by the District Director in order to prevent overloading the laboratory. If any evidence of animal fat is found in the finished vegetable shortening, then the corresponding raw vegetable oil samples may be examined to determine whether contamination was the result of contaminated incoming vegetable oils or a result of mishandling of edible animal fats within the establishment. Unused samples should be returned to the plant management.

Section 318.93(C)

Samples of animal fat should not be sent to the Meat Inspection Laboratory with a request for specie determination unless the inspector has reason to believe the product is mislabeled, such as tallow in lard or lard in "Beef Tallow."

318.94 Inspectors assigned to rendering or refining jobs are to include in their routine inspection duties a critical examination of samples run through a white filter cloth or filter paper to illustrate any possible contamination that might be present. If the product is solid or semisolid, it should be melted before filtration. At least one such examination should be

made on product representing a production lot. Samples may also be sent to the laboratory serving your Circuit for evaluation, but the detection of contamination should remain an establishment responsibility with the inspector assuring by his own examinations that no visible contaminants are present.

Any lot found to be contaminated with foreign material should be retained and corrective action taken.

318.95 When extenders having 2.0 percent limits are mixed with extenders having 3.5 percent limits, the following amounts of each may be used.

Ounces Per 100 Pounds of Product

<u>2.0 Percent</u>	<u>3.5 Percent</u>
32	0
31	1.8
30	3.5
29	5.3
28	7.0
27	8.8
26	10.5
25	12.3
24	14.0
23	15.8
22	17.5
21	19.3
20	21.0
19	22.8
18	24.5
17	26.3
16	28.0
15	29.8
14	31.5
13	33.3
12	35.0
11	36.8
10	38.5
9	40.3
8	42.0
7	43.8
6	45.5
5	47.3
4	49.0
3	50.8
2	52.5
1	54.3
0	56.0

318.96 The following is permissible in order to inhibit mold growth on dry sausage during drying, storage and transportation.

Potassium sorbate in a 2½ percent water solution may be applied to dry sausage after stuffing and prior to drying. As an alternate procedure, casings may be dipped in a 2½ percent solution of potassium sorbate in water before stuffing.

Sausage treated with the potassium sorbate solution as described above must bear proper branding and labeling, such as "dipped in a potassium sorbate solution to retard mold growth."

318.97 Samples. Microbiology Laboratory.

The following guidelines describe how to obtain and ship samples to laboratories of the Technical Services (TS) Division for microbiological, serological, or antibiotic residue analyses, and how to obtain consultative services.

Perishable Product Samples for microbiological or antibiotic residue analysis that are received in the laboratory in a thawed condition will not be analyzed. Analysis of such samples produces data of no value since the results would not necessarily reflect the original condition of the product.

Tissue Samples for serological analysis (species identification) that are received in the laboratory in a decomposed condition will not be analyzed.

A. CONSULTATIVE SERVICES

1. Meat inspectors may obtain consultative service on microbiological sampling problems by letter or by telephone, if urgent, addressed to Head, Microbiology Group, TS Division. Use of this service will help to assure that samples are taken in such manner, from such sources, and in such numbers that the analysis will produce meaningful data. Data obtained from analysis of samples that are improperly obtained, packed, handled, or shipped are of little value. Some problems may be best solved by reference to reports developed from a study of scientific literature rather than by analysis of samples.

2. Requests for consultative services, except the most routine, shall be handled as follows:

a. Meat inspectors shall obtain prior clearance from the Officer in Charge.

b. The Technical Services Division shall inform the appropriate Division (Livestock Slaughter Inspection Division or Processed Meat Inspection Division) of any in which the Division may have an interest.

B. SAMPLES

1. Sampling Programs

a. Sampling may be prompted either from the field or from Washington, D. C. Inspectors who need bacteriological data

may, on approval from the Officer in Charge, take samples for this purpose. They will be accepted for analysis if they meet the requirements spelled out elsewhere in this Manual.

b. Sampling by field personnel may be requested by Processed Meat Inspection Division, Livestock Slaughter Inspection Division, or Technical Services Division through the District Directors or their deputies. Before sampling programs are begun, the requesting Division should first consult with Head, Microbiology Group to determine that the sample load can be accommodated by the laboratory.

c. Washington Divisions shall keep each other appropriately informed on sampling that is of mutual interest.

2. Sampling Procedures

a. Aseptic Sampling Kit. An aseptic sampling kit, consisting of sterile Whirl-Pak bags, 2 spoons, 1 pair of scissors, 2 pairs of forceps, 1 knife, and tongue depressors is available. The kit is enclosed in a typical styrofoam shipping container, which has been placed in an outside box marked "Aseptic Sampling Kit Inside." Kits may be obtained from Officers in Charge who are held accountable for the reusable components (spoons, scissors, knife). If no kit is available, glass fruit jars sterilized in a pressure cooker, and sterilized implements such as scissors, knives, and spoons may be used.

Each item in the kit shall be used once after which it shall be handled as follows:

(1) Discard forceps and tongue depressors.

(2) Send scissors, knife, and spoons to the laboratory; or wash, resterilize them for reuse, and store them at the office of the Officer in Charge. To resterilize, use one of the following methods:

(a) Wrap and sterilize in an autoclave or pressure cooker at 250°F. (15 lbs. pressure.)

(b) Wrap and sterilize in a dry oven at 340°F. for two hours. (A household oven is satisfactory.)

(c) Flame them briefly with a propane torch, and cool them in air without permitting them to touch non-sterile surfaces. Caution: Too much heat by flaming will damage scissors and knives. Be careful with open flames where there are combustible materials.

b. Size and Number of Samples for Microbiological Analysis. Five to ten ounces of product (100 to 200 grams or ml.) or a

consumer-size package of final product, will usually be enough for a sample. Take samples representative of the product in question, and, if possible, of product known to be normal. Identify the normal units. The number of samples taken for analysis requires some degree of judgement. On the one hand, the significance of findings increases with the number analyzed; on the other, our laboratory facilities are limited. Therefore, the number of samples to be drawn will be designated by the Head of the Microbiology Group on all survey programs which TSD initiates; and PMID or LSID will designate the number of samples to be drawn for control programs which they initiate. On individual tests initiated in the field, the OIC lacking other guidelines, will consult with the Planning Branch of either PMID or LSID.

c. Aseptic Sampling. Take and maintain samples intended for microbiological analysis in a manner that will produce as little change as possible in the types and numbers of bacteria present. Use a sterilized implement to cut or pick up each sample. (The plant worker who ordinarily handles the product at this point in the production line may be asked to do this with his hands instead of using sterile implements. This is an acceptable sampling technique because the worker touches the product anyway.) Do not yourself touch the product, the lip of the sterile container, or the part of the sterile implement that will contact the product. Place the sample into a sterile Whirl-Pak bag. Fold the top of the Whirl-Pak bag several times and close the wire end over the fold. Freeze the sample without delay.

d. Non-Aseptic Sampling. Samples intended for species (serological) identification or antibiotic residue analysis need not be taken aseptically, but should be packed and shipped as described in Section C 1 a through j (omitting e), below. Freeze the sample without delay.

C. PREPARING AND SHIPPING SAMPLES

1. Perishable Product and Tissue Samples.

a. Obtain styrofoam shipping containers enclosed in two cardboard boxes from the Officer in Charge. Line the styrofoam container with the large plastic bag supplied with the container. Chill the open styrofoam container and cardboard boxes overnight in a freezer before using them.

b. Freeze perishable products (liquids, semi-liquids, meats, and tissues) immediately after sampling. Hold them overnight in a freezer (preferably a sharp freezer).

c. Place the frozen bagged sample into a second plastic bag; close the second bag, then wrap in butcher paper or newspaper.

Place the package into the prechilled, lined, styrofoam container.

- d. Pack newspaper or towelling around the package so that it will be protected during shipment.
- e. If an aseptic kit has been used, and needs sterilizing by the laboratory, enclose scissors, knife, and spoons.
- f. Add about 5 pounds of dry ice, wrapped in paper.
- g. Enclose the applicable Laboratory Sample Form.
- h. Close the open end of the liner bag as a precaution against leakage.
- i. Close the styrofoam container and the two boxes. DO NOT TAPE SEAL. USE CORD.
- j. Label carton lids (See F). Send by air mail, special delivery, to the laboratory. Mail only on Monday or Tuesday. Samples must be received during the work week. Unless otherwise instructed, send samples to: Microbiology Laboratory, Technical Services Division, C&MS, USDA, P. O. Box 348, Beltsville, Maryland 20705.

2. Dry Product Samples. Do not freeze dry products (dried milk, dried breeding mix, dried eggs, dried spices). To ship:

- a. Place the unfrozen dry product in any suitable, strong container. Do not pack with dry ice.
- b. Send by regular mail to the laboratory.

3. Canned Goods. NEVER MAIL HARD SWELLS. THEY WILL BURST EN ROUTE.

- a. Shelf-stable: Mail several abnormal cans (except hard swells) and several normal cans to the laboratory.

Send normal cans by any suitable means, without refrigeration.

Chill abnormal cans (except hard swells) in the refrigerator (not the freezer) overnight. Wrap each chilled abnormal can in a plastic bag, then in paper. Place in prechilled styrofoam container without dry ice; or add only about 1 pound of well wrapped dry ice. Close and mail in accordance with C 1 g through j.

- b. Non-shelf-stable: Mail several abnormal cans (except hard swells) and several normal cans to the laboratory. Chill all cans in the refrigerator (not the freezer) overnight. Wrap

each chilled abnormal can in a plastic bag, then in paper. Place both normal and abnormal cans in prechilled styrofoam container without dry ice; or add only about 1 pound of well wrapped dry ice. Close and mail in accordance with C 1 g through j.

D. BACKGROUND INFORMATION REQUIRED

Enclose with all samples submitted for microbiological analysis the appropriate laboratory sample form as well as a full description of background information that answers:

1. What prompted the sampling?
2. How, when, and where was the sample obtained?

Such information will aid the microbiologist to select appropriate tests and to interpret results.

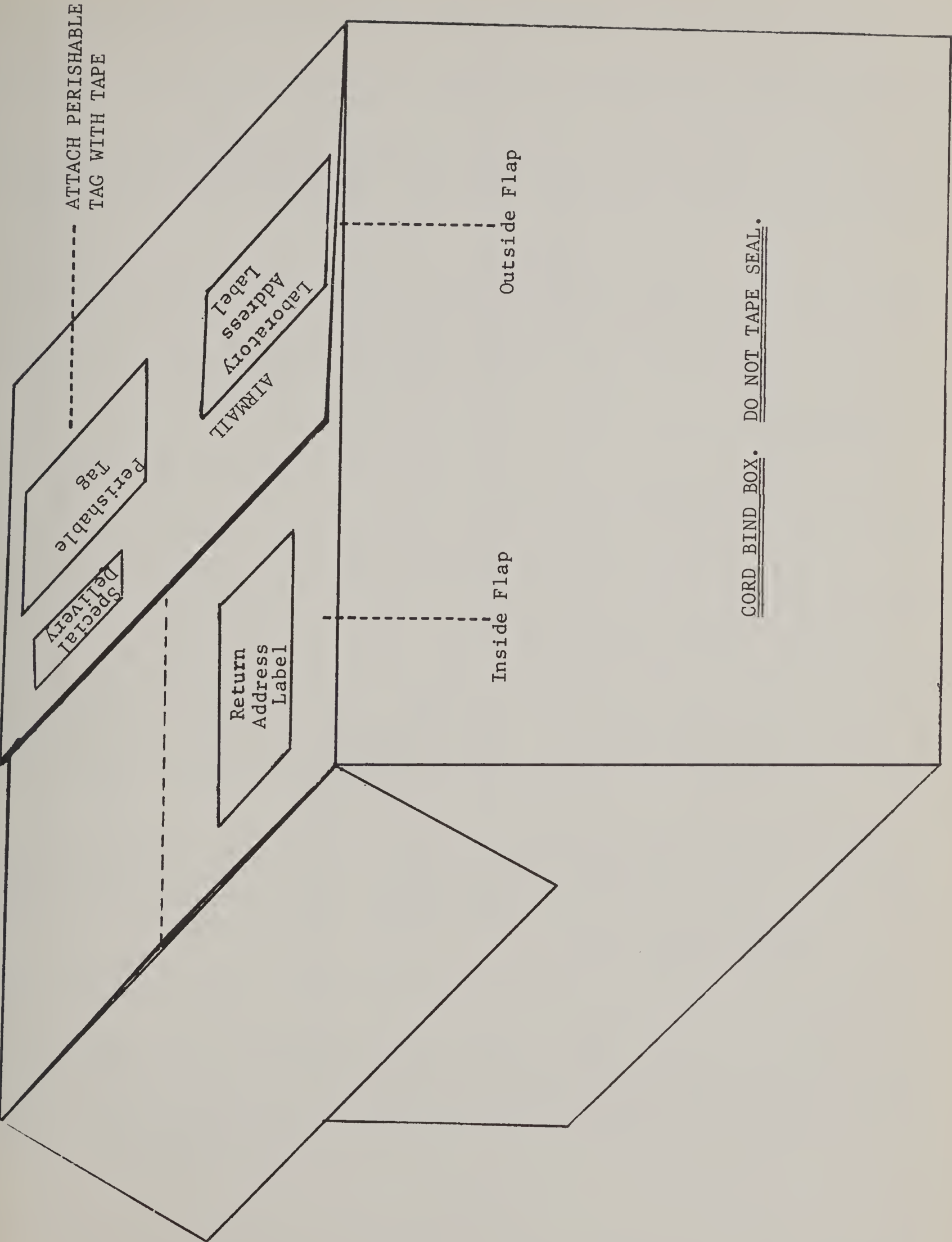
If product is related pending analysis, so indicate. Analysis and reporting will then be expedited.

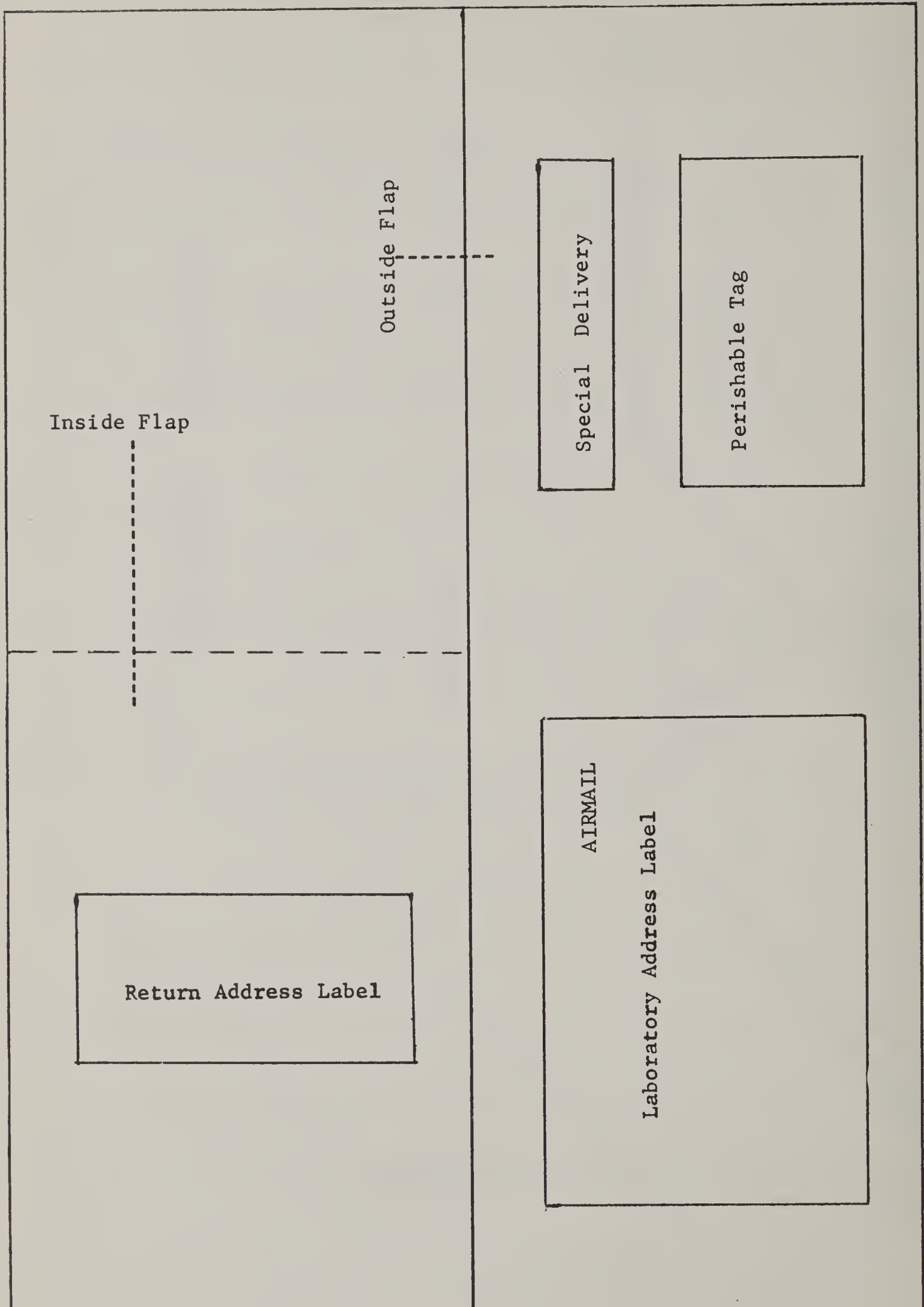
E. LABORATORY WORKLOAD

Before shipping more than 10 samples, consult Head, Microbiology Group, TS Division, in order that the laboratory can plan its program and be prepared to handle the material.

F. DIAGRAMS

Diagrams for labelling cartons containing styrofoam shipping containers follow:





PART 320 - REPORTS

320.1 Form MI-402-1, Summary of Ante-Mortem Examination, (use is optional) should be filed with the Officer in Charge copy of the post-mortem report.

Form MI-402-2, Identification Card Ante-Mortem, should be completed by a veterinary ante-mortem inspector for each U. S. Suspect animal. Form MI-402-2 should be filed with the Officer in Charge copy of the post-mortem inspection report.

Form MI-403, Ante-Mortem and Post-Mortem Inspection Summary. This form is to be prepared by the veterinarian on final post-mortem inspection. Two copies are required; the original should be sent to the appropriate Market News officer, the duplicate copy is for the Circuit file. An extra copy may be prepared for the establishment, if it is requested.

A no-kill report should be rendered when applicable, except for Sunday.

The information required on the top of the form is self-explanatory for the most part. Do not enter the name of a Subcircuit; always use the name of the parent Circuit. Total hours should be reported in quarter hour increments. Chain speed should be reported as carcasses per hour, and the recorded speed should be the highest chain speed attained during the operation and not related to the carcasses reaching the cooler hourly. "Bed" dressing operations should also be reported in the chain speed "block." The highest actual rate per hour of animals dressed during a day's operations should be reported. Species names to be used are swine, cattle, calves, sheep, goats or horses. A further breakdown for cattle is necessary as indicated on the form; these are bulls, steers, heifers and cows. Stags and uncastrated male cattle dressed on the cattle kill should be reported as bulls. Castrated male cattle dressed on the cattle kill should be reported as steers. All bovine animals dressed on the calf kill should be reported as calves regardless of size or sex.

The supervisory veterinary meat inspector should not only summarize on this form the information contained on Form MI-403-6, Report of Final Post-Mortem Inspection of Retained Carcasses, but also the information recorded on Form MI-402-1, Summary of Ante-Mortem Examination, by the ante-mortem inspector. Each Circuit should maintain its own record of holdovers.

Each block on the form in which entries of diseases and conditions are to be made contains a letter.

In the blocks with the letter "R" should be recorded, opposite the appropriate disease or condition, the retention of carcasses on the regular kill; in the blocks with the letter "S" the disposition of suspects; in the blocks with the letter "A" the condemnations on ante-mortem inspection, and the letter "T" primal parts condemned.

For example, two cattle carcasses on regular kill were passed without restriction on account of actinomycosis, but both heads were condemned. On Form 403 on the line for actinomycosis, the figure "2" should be entered in the block "R" under the heading "without restriction." If the two carcasses were suspects instead of being retained on the regular kill, the figure "2" should be entered in the block "S" under the heading "without restriction." The two heads should be reported as "2" in the "T" block under "Parts." No breakdown should be made between primal parts of suspects and carcasses retained on regular kill. The combined total should be entered in the blocks under the heading "Parts."

Entries on this form should record only the disposition made by the final inspector and not the disposition of carcasses and parts later made by establishment.

Example 2. If Form MI-402-1, Summary of Ante-Mortem Examinations, showed one suspect released, that is, released to a farmer, etc., but not released for slaughter, one carcass condemned for pyrexia and one for emaciation, then on Form 403 at the bottom of the sheet enter the figure 1 in the block opposite "Suspects Released," Code 9315, and the figure 1 in the block opposite "Pyrexia," Code 9535. For the carcass condemned for emaciation, the figure 1 should be entered in the block with the letter "A" under the heading "Condemned," on the line for "emaciation," Code 02.

The primary purpose of this form below the heading "Disposition of Retained Carcasses and Parts," is to record the diseases and conditions found rather than the number of animals found with diseases and conditions which caused the retention of animals. Therefore, a carcass may be reported more than once.

Example 3. A tuberculosis reactor showing lesions may also have actinomycosis; in this case if the carcass was "passed without restriction," the figure 1 should be entered in the "S" block under actinomycosis and again in the "S" block under tuberculosis reactor showing lesions.

Swine, sheep, and goat livers which are condemned should be reported for each establishment in pounds on Form MI-403 under Code 7831. To assure a uniform basis of reporting, the determination of condemned livers in pounds should be developed as follows:

A. Swine

It has been determined that 3 pounds per hog is the average liver yield, except that in cases where the slaughter is predominantly sows and boars the average liver yield per hog is 5 pounds. To arrive at the total pounds of livers condemned, multiply by 3 or 5 pounds (average yield) the number of animals slaughtered, and then subtract the total pounds of livers saved for food by the establishment. This will provide the number of pounds of livers and trimmings condemned to be reported on Form MI-403, Code 7831.

Section 320.1(A)

Example: 2,000 (total hogs slaughtered) x 3 = 6,000 (potential yield).

6,000 - 5,400 (pounds packed by establishment) = 600 (pounds of condemned livers).

B. Sheep and Goats

Average liver yield per animal is 1.5 pounds. The same procedure as for swine is used to arrive at the total pounds condemned.

In some cases the total pounds of livers saved by the establishment will not be available until the following day.

The following diseases and conditions which are not listed on Form MI-403, should be reported with the diseases and conditions indicated below. If a disease or condition is found that is not listed below, then the veterinarian should use his professional knowledge in entering the finding. This list should in no way influence the veterinarian in the preparation of Form MI-403-6, Report of Final Post-Mortem Inspection of Retained Carcasses, as he should continue to report diseases and conditions as he finds them.

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Adenocarcinoma	Carcinoma	40
Adenoma	Misc. Neoplasms	49
Adrenal Gland Tumor	Misc. Neoplasms	49
Agonal Hemorrhages	Gen. Misc.	99
Anaphylactic Reaction	Gen. Misc.	99
Anemia	Misc. Degen. and Dropsic. Cond.	09
Aneurysm	Gen. Misc.	99
Angioma	Misc. Neoplasms	49
Ankylosis	Bone Conditions	82
Anthelmentic Residue	Residue-Drug	04
Antibiotic Residue	Residue-Drug	04

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Arteriosclerosis	Gen. Misc.	99
Ascites	Misc. Degen. and Dropsic. Cond.	09
Atelectasis	Normal	87
Aujeszky's Disease	Misc. Infectious Disease	29
Balanitis	Misc. Inflammatory Disease	39
Blackleg	Misc. Infectious Disease	29
Bovine Rhinotracheitis	Mucosal Diseases	27
Brisket Disease	Misc. Degen. and Dropsic. Cond.	09
Bronchitis	Misc. Inflammatory Disease	39
Bursitis	Misc. Inflammatory Disease	39
Calcification	Misc. Inflammatory Disease	39
Calculi	Misc. Inflammatory Disease	39
Calf Diptheria	Misc. Infectious Disease	29
Cancer Eye	Epithelioma	41
Cellulitis	Misc. Inflammatory Disease	39
Chlorinated Hydro- carbon Residue	Residue- Pesticide	03

Section 320.1(B)

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Chronic Granulomatous Disease of Swine	Malignant Lymphoma	42
Cicatrix	Gen. Misc.	99
Cirrhosis	Misc. Inflammatory Disease	39
Clay Pigeon Poisoning	Toxemia	72
Coccidiosis	Misc. Infectious Disease	29
Copper Poisoning	Residue-Other	05
Corneal Dermoid	Misc. Neoplasms	49
Cryptorchid	Sexual Odor	90
Cystitis	Misc. Inflammatory Cond.	39
Cysts, Congenital	Gen. Misc.	99
Defective Stick Wound	Asphyxia	81
Delayed Evisceration	Contamination	83
Demodectic Mange	Skin Conditions	91
Dermatitis	Skin Conditions	91
Diamond Skin	Skin Conditions	91
Distomiasis	Misc. Parasitic Cond.	59
Dropsy	Misc. Degen. and Dropsic. Cond.	09
Echinococcosis	Misc. Parasitic Cond.	59
Edema	Misc. Degen. and Dropsic. Cond.	09

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Embryonal Nephroma	Misc. Neoplasms	49
Empyema	Abscess; Pyemia	70
Endocarditis	Pericarditis	35
Eperythrozoonosis	Misc. Infectious Disease	29
Ergot Poisoning	Misc. Inflammatory Disease	39
Erythema	Skin Condition	91
Exotosis	Bone Condition	82
Fat Necrosis	Misc. Degen. and Dropsic. Cond.	09
Feed Additive Residue	Residue-Drug	04
Fibroma	Misc. Neoplasm	49
Fistula	Abscess; Pyemia	70
Folliculitis	Skin Condition	91
Fracture	Bruises; Injuries	86
Fungicide Residue	Residue-Pesticide	03
Gall Bladder Tumor	Misc. Neoplasm	49
Gangrene	Misc. Inflammatory Disease	39
Goiter	Gen. Misc.	99
Granulosa Cell Tumor	Misc. Neoplasm	49
Hemangioma	Misc. Neoplasm	49
Hematuria	Gen. Misc.	99
Hematoma	Bruises; Injuries	86

Section 320.1(B)

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Hemochromatosis	Misc. Pigmentary Cond.	69
Hemoglobinuria	Gen. Misc.	99
Hepatization, Pulmonary	Pneumonia	36
Hepatoma	Misc. Neoplasm	49
Herbicide Residue	Residue-Pesticide	03
Hernia	Gen. Misc.	99
Hydrocephalus	Misc. Degen. and Dropsic. Cond.	09
Hydronephrosis	Misc. Degen. and Dropsic. Cond.	09
Hydrothorax	Misc. Degen. and Dropsic. Cond.	09
Hyperkeratosis	Gen. Misc.	99
Hyperplasia	Misc. Inflammatory Disease	39
Hypoderma Sp.	Misc. Parasitic Cond.	59
Induration	Misc. Inflammatory Disease	39
Infarct	Misc. Inflammatory Disease	39
Influenza	Misc. Infectious Disease	29
Iron Residue (Injectable)	Residue-Drug	04
Joint-III	Misc. Infectious Disease	29
Keratitis	Misc. Inflammatory Disease	39
Kidney Worms	Stephanuriasis	52

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Kyphosis	Bruises; Injuries	86
Laminitis	Misc. Inflammatory Disease	39
Lordosis	Bruises; Injuries	86
Lungworms	Misc. Parasitic Cond.	59
Lymphadenoma	Misc. Neoplasm	49
Lymphoblastoma	Malignant Lymphoma	42
Lymphocytoma	Malignant Lymphoma	42
Lymphoma	Malignant Lymphoma	42
Lymphosarcoma	Malignant Lymphoma	42
Melanosarcoma	Sarcoma	43
Mesenteric Emphysema	Gen. Misc.	99
Mesothelioma	Misc. Neoplasm	49
Metallic (Heavy Metal) Poisoning	Residue-Other	05
Mucormycosis	Misc. Infectious Disease	29
Nasal Granuloma	Misc. Infectious Disease	29
Neoplasm	Misc. Neoplasm	49
Nerve Sheath Tumor	Misc. Neoplasm	49
Ochronosis	Misc. Pigmentary Cond.	69
Oesophagostomiasis	Misc. Parasitic Cond.	59
Omphalophlebitis	Misc. Inflammatory Cond.	39
Orchitis	Misc. Inflammatory Cond.	39

Section 320.1(B)

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Organic Phosphate Residue	Residue-Pesticide	03
Ostempyesis	Bone Condition	82
Osteohemachromatosis	Bone Condition	82
Osteomyelitis	Bone Condition	82
Osteitis	Bone Condition	82
Otitis	Misc. Inflammatory Disease	39
Pale Muscle Tissue of Swine	Normal	87
Papilloma	Misc. Neoplasm	49
Pentastomiasis	Misc. Parasitic Cond.	59
Periarteritis Nodosa	Misc. Inflammatory Cond.	39
Periostitis	Bone Condition	82
Phlebitis	Misc. Inflammatory Disease	39
Photosensitization	Skin Condition	91
Pin Point Nodes	Abscess; Pyemia	70
Piroplasmosis	Misc. Infectious Disease	29
Placenta, Retained	Metritis	33
Pneumonitis	Pneumonia	36
Polioencephalomalacia	Misc. Inflammatory Disease	39
Porphyria (Pink Tooth)	Misc. Pigmentary Cond.	69
Proctitis	Misc. Inflammatory Disease	39

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Prolapse (Rectal Uterine or Vaginal)	Misc. Inflammatory Disease	39
Prophylactic Residue	Residue-Drug	04
Pyometra	Metritis	33
Pyelonephritis	Nephritis; Pyelitis	34
Rhinitis	Misc. Inflammatory Disease	39
Sarcomatosis	Sarcoma	43
Sarcosporidiosis	Misc. Parasitic Cond.	59
Scabies	Skin Condition	91
Scoliosis	Bruises; Injuries	86
Sinusitis	Misc. Inflammatory Disease	39
Soft Fat of Swine	Normal	87
Steatitis	Misc. Inflammatory Disease	39
Steatosis	Normal	87
Stephanurus dentatus	Stephanuriasis	52
Stomach Worm	Misc. Parasitic Cond.	59
Stomatitis	Misc. Inflammatory Disease	39
Streptothricosis	Misc. Infectious Disease	29
Sulfa Residue	Residue-Drug	04
Teratoma	Misc. Neoplasm	49
Therapeutic Residue	Residue-Drug	04
Thorny Headed Worm	Misc. Parasitic Cond.	59

Section 320.1(B)

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Thrombi	Misc. Inflammatory Disease	39
Thymoma	Misc. Neoplasm	49
Tranquilizer Residue	Residue-Drug	04
Ulcer	Misc. Inflammatory Cond.	39
Urticaria	Skin Condition	91
Vaginitis	Misc. Inflammatory Disease	39
Vesicular Exanthema	Vesicular Disease	28
White Muscle Disease	Misc. Inflammatory Disease	39
White Spotted Kidneys of Calves	Nephritis; Pyelitis	34
Xanthosis	Misc. Pigmentary Cond.	69

LIVERS CONDEMNED

<u>Unlisted Disease or Condition</u>	<u>Report on Form MI-403 as:</u>	<u>Code No.</u>
Actinomycosis	Misc.	7831
Congestion	Misc.	7831
Gallstones	Misc.	7831
Hobnail Liver	Cirrhosis	4831
Nutmeg Liver	Cirrhosis	4831
Stephanuriasis	Other Parasitic Conditions	6831

320.2 MI-404 Processing Operations at Official Establishments.

A. Form MI-404 provides for:

1. A weekly total of the quantities of products produced or processed at official establishments.

2. A weekly total of the quantities of canned products for commercial distribution.

3. Information to be used by the Meat Inspection Program in determining manpower needs and in assessing adequacy of inspectional program. The data is also released for publication in trade journals and official governmental publications.

B. The form is to be completed weekly by establishment management in original and two copies, as follows:

1. Fill in week code number, the month and day beginning the reporting period, the month, day and year ending the reporting period. Name of the Officer in Charge, circuit number and establishment number.

2. Enter the quantity of products, in pounds, produced or processed during the weekly reporting period, in the space to the right of each item in Part 1. Indicate finished weights, in all items, except "Cured or Placed in Cure," indicate green uncured weights. In Part 2 enter finished weights in space immediately under item.

3. There is no space for "write-ins."

4. Enter firm's name in the lower left-hand corner. The title and signature of the representative responsible for providing data must be entered in the appropriate space at the bottom.

C. Form MI-404 will be distributed in the following manner:

1. The establishment will give the original and one copy to the inspector assigned to establishment; and keep one copy for their files, if desired.

2. The inspector will:

a. Review information for completeness and accuracy. Reports containing omissions or obvious inaccuracies concerning product or weights should be returned for correction.

b. Sign in lower right-hand corner.

c. Mail original to:

Program Records Unit
C&MS Meat Inspection Administrative Staff
211 Stockyards Station
4101 South Halsted Street
Chicago, Illinois 60609

d. Retain duplicate in establishment file.

The items listed below should be reported under the following headings:

PART 1 - MEAT AND MEAT FOOD PRODUCTS

CODE NO.

CURED OR PLACED IN CURE

Do not include chopped or ground meats placed in cure for use in the same establishment in the preparation of sausage, luncheon meats, spiced ham, etc.

- 1012 Beef Briskets
 Green uncured weight of beef briskets only.
- 1019 Beef - Other
 Green uncured weight of all other beef items, except
 briskets. Include tongues, tripe.
- 1020 Pork
 Green uncured weight of all other beef items, include
 hams, bellies, picnics, shoulders, butts, hocks, plates,
 fat, backs, tongues, lips, snouts, jowls.
- 1030 Other Meats
 Lamb, mutton, veal, or products from these species.

SMOKED OR DRIED

This category is for reporting quantities of various types of smoked and dried meats. Record finished weights.

- 1122 Hams - Regular
 Bone-in or semi-boneless hams, either regular smoked or
 fully cooked. Do not include "Hams - Water Added."
- 1123 Hams - Water added
 Bone-in or semi-boneless smoked hams, include regular
 smoked and fully cooked.
- 1124 Hams - Boneless
 Smoked boneless hams - fully cooked or regular smoked.
 Include boned-rolled and tied, visking, etc.

CODE NO.

- 1125 Picnics - Regular
Bone-in or semi-boneless picnics, regular smoked or fully cooked. Do not include "Picnics - Water Added."
- 1126 Picnics - Water added
Bone-in or semi-boneless picnics, water added. Include regular smoked and fully cooked.
- 1127 Pork Butts
Do not include coppa or capicola.
- 1121 Bacon
Include only smoked bellies.
- 1129 Pork - Other
Loins, knuckles, spareribs, coppa, capicola, hocks, jowls, or other items not included in pork codes above.
- 1110 Beef
All beef and beef products - including tongues, rounds, insides, outsides, etc.
- 1130 Other Smoked or Dried Meats

COOKED MEAT

Record the finished weight.

- 1224 Hams
Water cooked, boiled or baked, or steam cooked. Do not include canned hams, or fully cooked smoked hams.
- 1229 Pork - Other
All pork or pork products, except hams, include feet, tongues, loins, loin rolls. Do not include items reported under "Smoked and Dried."
- 1210 Beef
Beef rounds, tongues, cooked corned beef, cooked cured beef.
- 1230 Other Cooked Meats

SAUSAGE

Report finished weights.

- 1310 Fresh finished
Breakfast sausage, pork sausage, fresh beef sausage, etc.

CODE NO.

- 1320 Dried or Semi-dried
 Dry salami, cervelat, pepperoni, summer sausage, smoked
 thuringer, pork roll, or other sausage produced and removed
 from drying rooms.
- 1330 Franks/Wieners
 All forms.
- 1335 Bologna
 Include regular and ring variety.
- 1340 Other Smoked and/or Cooked
 Liver sausage, braunschweiger, polish, smoked pork sausage,
 minced, roll, blood sausage, luncheon meat in casings or
 other sausage which has been smoked and/or cooked.
- 1410 LOAF; HEAD CHEESE; CHILI; JELLIED PRODUCT
- Souse, sulze, scrapple, liver pudding, blood pudding, chop
 suey, imitation sausage, imitation chicken, tamales (not
 canned), and turnovers.
- 1420 STEAKS; CHOPS; ROASTS; BONELESS CUTS
- Report the actual production of packed and to be packed fresh
 cuts, cube steaks, sandwich steaks, minute beef steaks, pork
 chops, packed fresh cuts, fabricated meat, steaks, chops,
 roasts and stew meat, and all other processed packed cuts,
 fresh or frozen. This item should reflect operations in hotel
 and restaurant supply departments wherein pork chops, lamb
 chops, veal chops, pork steaks, ham steaks, beef steaks, and
 all kinds of roasts are prepared. This item should also
 include cube steaks, sandwich steaks, and other similar items
 prepared in individual serving style, as well as chunk meats
 for stews, and liver which has been sliced for serving. It
 should also include beef that is prepared for the Army in the
 3 or 4-way style. Include bone-in and boneless beef, veal or
 mutton cuts but do not include organs or by-products.
- SLICED PRODUCT
- Report finished weight
- 1440 Bacon
 All sliced bacon including bacon ends and pieces.
- 1450 Other (Sausage; loaves; ham; luncheon meat)
 Sliced dried beef and any other sliced product.

CODE NO.

- 1460 HAMBURGER
- 1465 GROUND BEEF
- 1470 MISCELLANEOUS MEAT PRODUCT
- Chitterlings, cattle and calf feet scalded, calf heads, cooked tripe, cooked pork stomachs, and other processed products. Do not include fats, oils, leaf lard and compounds or canned meat or products that do not require further processing, such as brains, livers, hearts, kidneys, sweetbreads, etc.
- 1480 FROZEN AND UNFROZEN CONVENIENCE FOODS - Dinners; Entrees; Meat Pies; Specialities
Breaded product. Comminuted steaks, meat patties, ground shaped chops or steaks, breaded steaks.
- 1510 LARD - Rendered
- Prime steam lard, open kettle, rendered lard, and dry rendered lard.
- 1520 LARD - Refined
- Lard hydrogenated, refined, lard open-kettle refined, lard prime steam refined, and lard oil.
- 1540 EDIBLE TALLOW
- Beef fat rendered and mutton fat rendered, include oleo stock.
- 1550 PORK FAT - Rendered
- 1560 PORK FAT - Refined
- 1570 COMPOUND CONTAINING ANIMAL FAT
- Puff paste shortening, shortening prepared with animal fat; and miscellaneous fats and oils.
- 1580 OLEOMARGINE CONTAINING ANIMAL FAT
- Report the total production of all oleomargarine containing oleo, lard, rendered pork fat, or any other animal fats.
- 1590 CANNED PRODUCT - Commercial
- Include all canned products produced for commercial distribution.
- 1595 CANNED PRODUCT - Government

CODE NO.

Include all canned products prepared for any governmental agency under a contract.

5350 BEEF - BONED (Manufacturing)

Include all boneless beef, other than steaks, chops, or roasts reported under Code.

5360 PORK CUT

Determine quantity by multiplying the average dressed weight of the carcasses boned and/or cut.

5370 OTHER MEAT - BONED

Bone veal, mutton, or lamb.

6910 HORSE MEAT PRODUCT

Include all horse meat or products boned, cut, chopped, cured or rendered.

PART 2 - BREAKDOWN OF CANNED PRODUCT TOTAL

Report only canned products for commercial distribution. Do not include any canned products produced for governmental agencies.

2611-2612 LUNCHEON MEAT

Ham - Chopped
Ham - Chopped with Raisin Sauce
Ham - Spiced
Ham - Spiced Loaf
Luncheon Meat (Except Beef, See Codes)
Pork, Chopped
Pork, Corned
Pork, Loaf

2621-2622- CANNED HAMS (Whole or Fractional)
2623

Ham - (No Refrigeration Necessary)
Ham - (Requiring Refrigeration)
Ham - Smithfield Slices
Ham - Water Added

2631-2632 BEEF HASH

Corned Beef Hash
Roast Beef Hash

CODE NO.

2641-2642	CHILI CON CARNE
	Chili Con Carne
	Chili Con Carne with Beans
2651-2652	VIENNAS
	Sausage, Vienna
	Sausage, Vienna, in Barbecue Sauce
	Sausage, Vienna, Ends and Pieces
2660	FRANKS, WIENERS IN BRINE AND SAUCE
	Frankfurters
	Frankfurters - Cocktail
	Wieners
	Wieners with Barbecue Sauce
	Wieners, Cocktail, with Sauce
2670	DEVILED HAM
	Ham - Deviled
2680	OTHER POTTED OR DEVILED MEAT FOOD PRODUCTS
	Potted and Deviled Meats (Spread)
	Meat Spread
	Bacon Spread
	Corned Beef Spread
	Liver Spread
	Tongue Spread
	Tongue - Deviled
2691-2692	TAMALES
	Tamales
	Tamales with Chili Gravy
	Tamales, Cocktail in Broth
2710	SLICED DRIED BEEF
	Beef - Dried - Sliced
2721-2722	CHOPPED BEEF
	Beef - Chopped
	Beef - Loaf
2731-2732	MEAT STEW (All products)

CODE NO.

Beef - Stew
Lamb - Stew
Ox Tail Ragout

2741-2742 SPAGHETTI MEAT PRODUCTS (All types)

Chili - Spaghetti
Chili - Spaghetti with Meat, Beans, Sauce
Spaghetti and Meat with Sauce
Spaghetti and Meat Balls

2750 TONGUE (Other than Pickled)

Ox or Beef Tongue
Tongue, Lamb, Pork

2761-2762 VINEGAR PICKLED PRODUCTS

Pigs Feet
Pork Feet Cutlets
Pork Hocks, Vinegar Pickled
Sausage, Vinegar Pickled

2770 SAUSAGE

Sausage - Pork
Sausage, Pork, Patties
Sausage - Bulk
Sausage - Link
Sausage - Cocktail

2781-2782 HAMBURGER; ROASTED or CORNED BEEF, MEAT AND GRAVY

Beef Brisket
Beef - Corned
Beef and Gravy
Beef and Kidneys in Gravy
Beef - Meat Balls
Beef - Cocktail Meat Balls
Beef - Roast
Beef - Sandwich Steaks
Beef - Steak and Brown Gravy
Hamburgers
Pork and Gravy

2791-2792 SOUPS

Soups

CODE NO.

2811-2812	SAUSAGE IN OIL
	Sausage in Oil
2820	TRIBE
	Tripe
2830	BRAINS
	Brains
2840	CANNED LOINS AND PICNICS
	Canned Pork Loins
	Canned Picnics
2851-2852- 2861-2862	ALL OTHER WITH MEAT AND/OR MEAT BY-PRODUCTS
	Baby Foods
	Bacon
	Bacon (Vacuum Packed)
	Beef with Barbecue Sauce
	Brown Gravy with Sliced Beef
	Brown Gravy with Sliced Pork
	Frankfurters and Beans
	Frankfurters and Sauerkraut
	Ham - Hash
	Liver - Loaf
	Liverwurst
	Mutton - Corned
	Pork with Barbecue Sauce
	Scrapple
	Beans with Ham
	Beans with Bacon
	Beef Chop Suey
	Corned Beef and Cabbage with Potatoes
	Enchiladas with Meat in Chili Sauce
	Ham a la King
	Pate de Foie with or without Truffles
	Ravioli with Meat
	Sauerkraut and Franks
	Spareribs, Sauerkraut, Potatoes
	Veal Loaf
6940	HORSE MEAT (All kinds)
	Horse meat
	Horse meat and Gravy
	Gravy and Horse meat

320.3 MI-407, Meat and Meat Food Products Condemned on Reinspection and Destroyed. Only one class of product and one cause can be reported on each MI-407. Use only the classes of product and causes of condemnation printed on the form. When meat food product fabricated from more than one class of meat or meat byproduct is condemned, for purposes of reporting on this form, the predominant meat or meat byproduct component of the condemned product shall determine the class. When there is no rejection at the Circuit during the calendar month, a report should be submitted with statement, "There were no meat or meat food products condemned on reinspection and destroyed at this Circuit during the month of _____." Product such as fat and bones intentionally diverted by an official establishment to inedible channels, even when such product is decharacterized, should not be reported on this form. A copy of this form may be furnished the establishment on request. The inspector must not under any circumstances identify the rejections on Form MI-407 with any particular shipment or product received at the establishment. He is not in a position to maintain identity of incoming shipments to the extent that he can certify that the contamination was present at the time it was received nor is he in a position to certify to the amount of trimming necessary to bring the product into compliance. Therefore, he may issue the condemnation form at the request of the packer, but it would merely state that on any particular date a certain amount of product was condemned. The inspector should not allow the packer to use MI-407 as a means of obtaining repayment or adjustment from the shipper.

320.4 MI-407-4, Materials Rejected for Use. One form should be prepared, in duplicate, for each material rejected, and the original of the completed form should be sent to the Meat Inspection Program Records Unit, Chicago, Illinois, along with other MI reports. The duplicate copy is for the Circuit files. When there is no rejection at the Circuit during a calendar month, a report should be completed with the notation, "There were no materials rejected at this Circuit during the month of _____."

The left side of the report is for coding. One code number in each group is to be circled. In the spaces, on the right, the inspector is to write in detail the description of the material rejected, the cause, the disposition and the official agency notified. The quantity rejected should always be reported in pounds, if possible.

To assist you in determining under what categories items should be placed on the form, we have prepared the following lists:

A. Groupings For Classes of Materials Rejected.

1. Spices and Seasonings:

salt	nutmeg
sugar	allspice
pepper (black, red, white)	sage
monosodium	dextrose
glutamate	seeds
paprika	dill
garlic	caraway
oregano	fennel
chili mix/powder	mustard
bar-b-q powder	seasonings
mace	sausage
thyme	bologna
onion powder	loaf
ground spice	ham spices
anise	saucers
smoke flavoring	hot
cinnamon	pizza
coriander	honey
	syrup
	vinegar

2. Flour and Cereal Products:

wheat flour	wheat cereal
corn flour	potato starch
soya flour	bread
barley	batter mix
potato	cracker meal
rolled oats	corn meal
barley	macaroni
rice	spaghetti
farina	noodles
cereal binder	tapioca flour

3. Dairy and Egg Products:

nonfat dry milk	sodium caseinate
whole milk	eggs, whole, fresh
whole skim milk	egg white, fresh,
dry whole milk	frozen, powdered
whey	egg yolks, fresh,
breeding mix dip	frozen, powdered
process cheese spread	

4. Fruits or Vegetables (Fresh, Canned, or Dehydrated):

potatoes	pickles
peas	olives
carrots	beans
parsley	bean sprouts
onion	
pimientos	
tomatoes, fresh	
paste	
puree	
juice	

5. Soaps, Cleaners, Oils:

tripe cleaner	boiler compounds
toilet cleaner, etc.	metal cleaner
floor cleaner	clothes cleaners
oakite	hand soaps
general cleaner	mineral oil
brick cleaner	cotton seed oil
	paraffin

6. Equipment:

lard drums	string
ink	rope
cartons	jars
cording	bottles
paper	cans
plastic products	covers (lids)

7. Casings (Natural and Artificial):

casings
plastic overwraps
visking bags

8. Curing Agents:

pickle	prague powder
cures	sal brine
westphalia powder	

9. Miscellaneous:

bicarbonate of soda	antioxidants to prevent
vitamins	discoloration
gelatin	tenderizers
monoglycerides	vegetable oleo-
stabilizers	margarine

B. Grouping For Cause of Rejection of Materials.

1. Not in Compliance with Federal Regulations:

label not approved for use of rejected product
product not labeled
unauthorized color or flavor
ingredients in excess of authorized allowances
insufficient ingredients
manufacturer and/or address unknown
improper markings on product
product contains prohibited ingredients

2. Contamination:

contains insects and/or weevils
contains foreign material
rodent contamination present
wormy
unclean

3. Objectionable Odors, Taste, or Color:

excessive odors
over age
unstable color
rancid

4. Sour, Moldy:

decomposed
toxic

5. Unsound Canned Goods:

6. Unacceptable Equipment:

previously used cartons, boxes, barrels
rusty
improper operation
broken or cracked
chipped or peeling lining

7. Other:

C. Groupings For Classes of Disposition of Material Rejected.

1. Removed from the Establishment:

converted into animal feeds
used in nonfood departments

2. Returned to Manufacturer or Supplier:

3. Destroyed by Establishment:

sewerage
burned
garbage
denatured and removed
tanked

4. Held for Food and Drug Administration:

5. Other:

320.5 MI-412, Application for Export Certificate and/or Stamps. In Section A, No. 4, the exporter is to check whether a certificate and stamps are requested or stamps only. In No. 5, only one block should be checked since only one type of certificate and/or stamps can be requested on one form. We believe that there is sufficient space for the exporter to list all the products he wishes to export under one certificate in Section A, of No. 10 A and B. In Section B, No. 6, check the block "Yes but this is an additional report," when a certificate is issued in lieu of another certificate. All the items reported in 10 A and B of Section A have to be reported in one or more of the blocks in Part 7, "Product Codes and Pounds Exported," of Section B.

320.6 Form MI-422. The designations and instructions included on Form MI-422 are generally self-explanatory and should be followed closely. Item number 4 should be checked when the sample is collected at the retail level, and Item number 5 should be checked when the sample is collected by the supervisor. The product code called for in Item 9 is found on MI Form 422-A (October 1963). Do not assign a code number for nonmeat food products or samples for analysis for specification compliance work.

In those cases where both cereal and nonfat dry milk are added, check only the nonfat dry milk product code. Where a code is not indicated for a specific product, record it under miscellaneous of the general category -- examples, "Luncheon Meat Sausage - Code 340-91."

The area and station codes are the same as used on Form MI-404 . The laboratory codes are as follows:

<u>Name of Laboratory</u>	<u>Code</u>
Chicago, Illinois	1
New York, New York	2
St. Louis, Missouri	3
Kansas City, Kansas	4
San Francisco, California	6
Washington, D. C.	7
Omaha, Nebraska	8
Beltsville, Maryland	9

The laboratory will complete "Date of Findings," "Lab. No." and anything else omitted in the heading. The inspector will be notified if these omissions are extensive.

320.7 Form MI-427, Notice of Receipt of Unclean and Unsound Product, is available and should be used when federally inspected product is received at an official establishment and the condition of the product upon arrival reflects unfavorably on the proper preparation or the transportation of the product from the originating establishment. The form should be executed by the receiving station in quadruplicate. One copy should be forwarded to the District Director of the originating Circuit (where product was prepared); two copies forwarded to the originating Circuit; and one copy placed on file at the receiving station.

The condition reported will be checked into at the originating Circuit and a record of the findings and action taken will be recorded on the back of the forms. One copy will be placed on file at the originating Circuit and the remaining copy will be forwarded to the District Director of the originating Circuit.

The purpose of this form is to furnish the Officer in Charge at the originating establishment with information to assist him in requiring correction of establishment procedures. Therefore, it is essential that the information on contamination and its probable cause be as complete as possible. Was it caused by metal particles eroded from metal hooks? Were the quarters wrapped or covered? Was it dressing floor contamination? What type? This information is essential if the form is to serve a useful purpose to the receiving inspector.

The form is intended for internal use of the Program and is not to be issued to the establishment.

320.8 Form MI-440, Report of Informational Activities Performed for Consumers. Each employee shall submit this report on consumer activities performed concerning the Meat Inspection Program. This shall include consumer complaints, inquiries handled verbally or written, or any other consumer contact regarding our program. Technical Services Division shall

Section 320.8

coordinate and maintain a collection of these reports in a manner that will reflect the extent and effectiveness of our Consumer Protection Program and provide insight into consumer opinions and reactions.

The form shall be completed in duplicate. If additional space is needed, the reverse side may be used. The original shall be sent to: Labels, Standards and Packaging Branch, Technical Services Division, C&MS, U. S. Department of Agriculture, Washington, D. C. 20250. Duplicate goes to the District Director, Division Director or Staff Director as appropriate.

320.9 Form MI-441 has been developed to provide for the identification of labels that are transferred between Circuits in accordance with Section 317.13 of the Meat Inspection Regulations. The instructions printed thereon cover its usage and distribution.

320.10 Form MI-442 will aid inspectors in the review of proposed sketches and labeling material prior to their being forwarded to the Labels, Standards and Packaging Branch. The form was designed to be used as a tool by the inspector for making his review both comprehensive and systematic. The remarks section should be used to give additional information relevant to the review of the label and otherwise make the communication between the reviewing inspector and the Washington Labels, Standards and Packaging Branch as effective as possible.

One copy of the check list should be completed and forwarded with each label or sketch submitted for approval.

320.11 Form MI-455, Sanitation Report. Requires each inspector performing daily sanitation inspection in accordance with Part 308 of the Manual to complete Form MI-455 to report conditions. Complete an original and two copies. Insert the official establishment name, establishment number and dates covered for each weekly report. The inspector shall complete daily each applicable section beginning with Section A and going through Section H. Code designations for conditions found are (✓) for acceptable; (N) for needs improvement; (U) for unsatisfactory. Any item marked with an "N" or "U" should be briefly explained in "Remarks" section. For example, if an "N" or "U" is placed in the square in Section A, Item 1 (pens) for Monday, then in "remarks" section reference would be made to Section A, Item 1 and the deficiency explained.

Upon completing the report, the inspector shall sign in the signature block. He shall obtain a signature of a responsible establishment official on all copies in the space designated. The original shall be filed in the establishment Government office, one copy goes to the Officer in Charge, and one copy to a responsible establishment official. Questions shall be directed to Livestock Slaughter Inspection Division or Processed Meat Inspection Division as appropriate.

320.12 Forms MI-461, 461-1, 461-2, Establishment Review Guide, shall be prepared in duplicate by Livestock Slaughter Inspection Division Review Specialist, Deputy Directors for Slaughter, and others at the option of the District Director. Any item in a slaughtering establishment that is found

to be in other than an acceptable condition must be explained in a narrative writeup and attached to the form. The original of all forms prepared by the Review Specialists and Deputy Directors shall be forwarded to the Director, Livestock Slaughter Inspection Division. The duplicate will be sent to the District Director responsible for the plant reviewed. Copies prepared by others using the form will be distributed as directed by the District Director.

PART 321 - APPEALS

321.1 When an inspector's decision is questioned, the Officer in Charge makes a report to the appropriate District Director.

PART 322 - COOPERATION WITH LOCAL AUTHORITIES

322.1

A. Information furnished by meat inspection stations when diseased conditions are found among animals at slaughtering establishments, and giving point of origin, has been of great value in assisting Federal and State officials in controlling communicable diseases of livestock. This has been especially true with such diseases as tuberculosis, hog cholera, swine erysipelas, anthrax, vesicular diseases, cysticercosis, and various parasitic infestations.

All cases of such diseases as anthrax, blue tongue, cysticercosis in swine, hog cholera, scabies, scrapie, tuberculosis in cattle and the vesicular diseases should be reported. In cases where lots of animals are affected with such diseases as contagious ecthyma, cysticercosis in cattle, foot rot, mucosal complex, swine erysipelas and tuberculosis in swine, they should be reported. All information regarding the identity of the animal and its origin should be furnished. In case of scrapie or scabies the ANH inspector would like to see the animal. Because of the importance of this phase of our work, the Officer in Charge should give it his close attention and see that the necessary reports are forwarded.

Owners and operators of official establishments will recognize that aid given in the identification of lots of diseased animals will serve to further reduce the incidence of the disease among the livestock population in the areas served by such establishments, a reduction which will shortly be reflected in a direct return to both the producer and the packer through the avoidance of loss by condemnation of diseased animals or their carcasses.

B. Meat Inspection Program veterinarians are an essential part of the first defense team against accidental or intended introduction of foreign livestock disease which may gain entrance to this country. This would include diseases such as foot-and-mouth disease, rinderpest, African swine fever, contagious bovine pleuropneumonia, and Techen's disease.

With the rapid expansion of air freight services and the common practice of transporting livestock long distances by truck for slaughter, a domestic or foreign disease could be widely disseminated in a matter of hours.

Program veterinarians should study literature on foreign or rare domestic diseases and be alert to any symptoms not commonly observed in slaughter animals. If suspicious symptoms are observed, the nearest Animal Health Division field veterinarian should be contacted. If he cannot be reached the ANH veterinarian in charge in the state should be notified.

The ANH Division has an "Emergency Disease Eradication Organization" ready to go to work in each state.

The Washington office of Operations Branch, Livestock Slaughter Inspection Division should also be notified.

322.2 The reports made by inspectors will be on Form ANH-2-11C except those reporting tuberculosis. The original should be forwarded to Livestock Slaughter Inspection Division at Washington, one copy to the Veterinarian in Charge of the State of origin of the animals covered by the report, and a copy to the appropriate State livestock sanitary official of the State of origin. The form forwarded to Livestock Slaughter Inspection Division should be noted to show that the required distribution has been made of other copies of the report.

322.3 Form ANH-6-35 "non-reactors showing tuberculosis lesions" should be used by veterinary meat inspectors for reporting lesions of tuberculosis found during slaughter of all non-reacting bovine animals and whenever extensive tuberculosis infection in lots of swine is encountered. All animals found to have tuberculosis lesions as well as those which show lesions suspicious of tuberculosis should be reported even though all of the information about the origin of the animal cannot be obtained.

Each form completed should be identified in the upper right-hand corner by the establishment number where the animal was slaughtered and a case number starting with number 1 on July 1 of each year and running consecutively at each establishment. The form should be distributed in accordance with instructions appearing on it. Inspectors should furnish all information available about the identity of the animal in the space provided on the form.

322.4

A. In some instances, the identity of cattle is established at the slaughtering plant through the medium of eartags, stockyards sales tags, and similar identifying devices. In many instances, cattle from Western States can be identified more positively by means of hide brands. These brands are registered with the livestock authorities of the States and are identified as the cattle move through the sales barns, stockyards, and the like. Whenever possible, these brand identifications are to be shown along with eartag numbers and other identifying features on Forms ANH-2-11C and ANH-6-35 reports. Brand inspectors are located at many livestock centers. It is suggested that they be asked to assist in the brand identification of diseased animals.

B. The origin of animals that show tuberculosis lesions may be determined by the identifying tags on the animals when they are slaughtered. Inspectors should remove such identifying devices and hold them for at least 60 days following the date of the report to the Animal Health Division on Form ANH-6-35. This gives the field veterinarian an opportunity to obtain the identifying tag if this becomes necessary.

All information on both sides of the eartag or similar identifying device should be shown on Form ANH-6-35. It would also be helpful to show the composition or other description of the tag.

C. A three-section identification tag has been successfully used to identify the origin of cattle when tuberculosis is detected on regular kill. This method is particularly useful when the removal of the hide is done sometime before evisceration.

Section 322.4(C)

The three-section tag is used in place of the two-part carcass identification tag currently used in most establishments. The three-section tag may be placed with pins on the right ear. One tag is then removed and pinned to the head and the second tag is torn from the attached tag and placed on the carcass. An alternate method is to identify the hide by applying a tag to it by the use of back-tag cement instead of fastening the tag to the right ear by means of a metal deadlock fastener. This method eliminates the danger of the metal fastener interfering with hide processing. ANH will furnish the back-tag cement.

322.5 The bovine tuberculosis eradication campaign has been successful in reducing the incidence of this disease to a low level throughout the United States. In order to carry through with effective follow-up control measures, it is necessary to make use of a system that will locate the remaining few centers of infection. When these are located, disease control officials can concentrate their efforts in the areas where correction is needed. This effects a maximum of results with a minimum expenditure of time and money. The key point in this system is at the slaughtering plant where animals affected with tuberculosis can be identified and thus lead the investigators to the infected premises.

322.6 Each veterinarian should carefully study ARS-22-27, Special Report, "Mucosal Disease Complex" furnished him by ARS. Veterinarians and meat inspectors who perform ante-mortem and post-mortem inspection duties should be completely familiar with the symptoms of the disease conditions in this complex. This can be best accomplished through discussions by those concerned.

If any of the conditions of mucosal disease complex are observed, an immediate collect telephone report should be made to the veterinarian in charge, ANH Division, of the state where the animal originated. If the origin cannot be determined, then the veterinarian in charge of the state where the animal is being slaughtered should be notified. The telephone report should be confirmed by a report in writing on Form ANH-2-11C with a copy to the state livestock sanitary official and a copy to the Livestock Slaughter Inspection Division.

All cases of hog cholera-like symptoms or lesions in swine diagnosed by Meat Inspection personnel shall be promptly reported by collect telephone, to the Animal Health Division veterinarian in charge in the state in which such case or cases are diagnosed. The telephone report should convey as much explicit information as is possible to enable the Animal Health Division to carry out all investigative procedures necessary in locating the source of infection.

Time expended in the assembling of trace-back information and in the transmission of the report should be billed against the Animal Health Division on Form C&MS-488. The service should be identified as "Hog Cholera Detection" on C&MS-488. Basically, these billing instructions are the same as those outlined in Paragraph 311.6(E).

The Animal Health Division is extremely anxious to have meat inspection veterinarians report to them immediately any unusual conditions suggestive of a communicable animal disease whether found on ante-mortem or post-mortem inspection. Where such a condition is found, a collect telegram should be sent to

the veterinarian in charge of the Animal Health Division activities in the state where the animal originated.

322.7

A. The Meat Grading Branch, Livestock Division, Consumer and Marketing Service, of the Department makes acceptance examinations of meats and meat food products for procurement agencies. When the product is prepared in a federally inspected establishment and the specifications require special supervision, the local Meat Grading Service representative will ask for our constant supervision during certain portions of the processing. Most requests for constant supervision cover only the formulation of meat food products, and other processing phases used receive the usual supervision from a meat inspection standpoint.

Our personnel will maintain control of the identity of these products from the time they assume the responsibility for this specification compliance through all subsequent operations and until such time as the grader is prepared to make the final acceptance.

When our cooperation is desired, our personnel will be informed by the local Grading people, who will give the official number and name of the establishment involved, furnish a copy of the applicable specifications and indicate the processing operations for which we are to be responsible.

The grader will notify the inspector in time so that the latter may be prepared to assume his part of the work. When our inspector turns the product over to the meat grader, he will present to the grader for his signature, four signed copies of Form MI-416 containing the following information:

1. Name of agency for which product is being processed.

2. Name and item number of product being certified.

3. A specific statement covering the phases of processing that are being certified.

4. Number of hours charged, designated as either basic or overtime or both, as the case may be. Time for laboratory examination should be shown separately. (Although the number of hours are shown, the hourly rate should not be put on the four forms. This time must be the same as the corresponding time on Form C&MS-488).

Section 322.7(A)

The completed forms should be distributed as follows: The original copy should be used to support the billing and attached to C&MS-488 that is sent to the Finance Division, Administrative Fiscal Branch, Hyattsville, Maryland. Two copies should be given to the Grader. The fourth copy should be sent to the Meat Inspection Office, Chicago, Illinois. The fifth copy is the station record.

On C&MS-488 under "Remarks" should be a statement which will connect it with Form MI-416 in the event the two become separated. The statement would show the number of the establishment where the product was prepared and in addition some identifying notation such as "Pennsylvania State Contract." C&MS-488 should show that the billing is to be made against the Meat Grading Branch.

B. The Meat Grading Branch, Livestock Division, Consumer and Marketing Service, has available a Product Examination Service on fresh and frozen meat for use by the industry. It is available to carriers and other interested persons desiring a certification on the physical characteristics of the product at the time of examination only. Occasionally this determination may involve a question of wholesomeness. In these cases the Meat Grading Branch may call on the Meat Inspection Program personnel for assistance. Officers in Charge are authorized to respond to this request provided the product can be identified as "U.S. Inspected and Passed" product. Charges for the time of the inspector will be made in the same manner as for specification examination work.

C. A voluntary service has been developed by the Meat Grading Branch available to producers who desire to have carcass grades and/or other factors of cattle certified. The Meat Inspection Program has agreed to perform this identification at time of slaughter for which reimbursement will be made on a per head basis.

Identification procedure. Federal meat graders may request Officers in Charge to provide service in federally inspected plants for maintaining identity of slaughtered animals and for corresponding carcasses.

A back tag for identifying each live animal will be issued to the applicant or his representative (livestock owner or broker) by a member of the Meat Grading Branch. The applicant or his representative will be responsible for placing the back tag on each animal he desires to have graded and for identifying the cattle for the grader at the slaughter's livestock holding pens. The Meat Inspection Program has recommended that the paper back tag be placed on the animals in a similar manner to the market cattle identification procedure. The paper back tag should be located on the foreshoulder of each animal to be identified. To reduce the risk of losing back tags, identification by the applicant or his representative should be done no earlier than one day prior to slaughter of the animal.

The back tag numbers of all animals will be listed on a form prepared by the grader in triplicate identified as the live cattle list. The producer's name and address and the number of cattle involved are to be entered on the form. Prior to slaughter of the animal, one copy of the form will be given to the Meat Inspection Program inspector responsible for the slaughter department,

together with sufficient number of USDA wire seals and metal carcass tags, which must bear numbers corresponding to the numbers on the back tags placed on the live cattle. The instrument for applying the tags will be provided by the Grading Branch.

At federally inspected establishments, the veterinary supervisor or his assistant will attach the appropriately numbered metal carcass tag to each carcass. The tag will be attached to the carcass with the USDA wire seal before the hide is removed and after comparing the wire tag seal number with the back tag number to verify they are duplicate numbers. It will remain on the carcass until the grader has made final positive identification of the carcass and has obtained the grade and other desired information. It is recommended that the metal tag be placed on the leading half of the carcass. The veterinary supervisor responsible for the slaughter department will issue certificates to the grader certifying that the metal carcass tag number placed on each carcass corresponds to the back tag number of each live animal in the lot. In the event that animals are missed on the slaughter floor or the tag is missing from the animal when it arrives on the slaughter floor, it should be indicated on the certificate. The meat grader will furnish certification forms to the veterinary supervisor in duplicate. The following statement will appear on the form and be completed as follows:

I, (Name of Inspector), certify that I attached USDA metal carcass tags numbered through with USDA wire seals to carcasses which bore on the hides prior to skinning paper USDA back tags bearing corresponding numbers and that the number I placed on each individual carcass matched the number of its tag.

It will not be necessary to make a billing for this service. The Meat Grading Branch will record the number of cattle identified from the inspector's certification form and reimburse the Meat Inspection Program for the number of animals identified at the rate agreed upon by both Programs. This will be done at the Washington office.

322.8 The broker, commission agent, packer, or other responsible person concerned with importation has the responsibility to notify the Officer in Charge when Canadian cattle are received at an official establishment and to identify the cattle to the inspector concerned. After the imported cattle have been slaughtered, notification to that effect should be sent to the Animal Health Division Inspector in Charge at the border point of entry on Form ANH-17-33, "Animals Imported for Immediate Slaughter." It is not expected that this coverage will be extended to plants not operating under Federal Meat Inspection. A space is provided on Form ANH-17-33 for indicating tuberculosis lesions found in such animals. When tuberculosis lesions are found in cattle from Canada, one copy of Form ANH-6-35 should be prepared and forwarded to the Washington office of the Animal Health Division. The form should carry a statement such as "Origin of Animal Canada."

322.9

A. Meat Inspection personnel will supervise the cleaning of trucks and trailers containing animals affected with an infectious disease when received at federally inspected packing plants.

In order to obtain approval for handling reactors, packing plants must provide adequate facilities and services for the cleaning and disinfection of vehicles transporting brucellosis reactor cattle with a permitted disinfectant as provided by Federal and state regulations.

Information about methods to be used in cleaning and disinfecting vehicles is given in Part 71, Subchapter C, Chapter I, Title 9 of the Code of Federal Regulations.

The following procedure should be used in cleaning trucks and trailers:

Once the plant employee has been properly instructed as to the procedure to follow in cleaning and disinfecting trucks, it will not be necessary for the inspector to personally supervise the disinfection of each and every truck. When the inspector is satisfied that the plant employee can be depended upon to do a good job, supervision by the inspector may be limited to personally observing the work at irregular intervals during the day. The inspector should be particularly interested at the time he is observing the work that-

1. The trucks have been properly cleaned prior to the application of the disinfectant.

2. The spraying outfit is of sufficient size and is working satisfactorily.

3. There is an ample supply of a permitted disinfectant on hand.

4. The mixture of the disinfectant is of proper strength.

5. The entire interior surface, including the inner surfaces of the truck doors, is saturated with a permitted disinfectant.

It is not necessary to forward Forms ANH-3-62 or ANH-3-62-A covering the disinfection of trucks to the Washington office of the Animal Health Division. However, the plant employee should keep a record by truck license number of each truck cleaned and disinfected. No placard ANH-2-62-C need be applied to trucks unless requested by the owner or driver of the truck.

Billing for this service should be made against the Animal Health Division on Form C&MS-488 and should include the supervision time, time involved in preparing forms and attaching placards, as well as cost of telephone calls.

B. Meat Inspection personnel will supervise proper handling of railroad cars containing animals affected with an infectious disease received at federally inspected packing plants at locations where Animal Health employees are not stationed.

Information about methods to be used in cleaning and disinfecting the cars is given in Part 71, Subchapter C, Chapter I, Title 9 of the Code of Federal Regulations.

The procedures outlined below should be followed:

1. As soon as it is ascertained that an infectious car has been received, a placard ANH-3-62-B should be securely attached to each side of the car. Notice should be given promptly over the telephone to the responsible railroad official and confirmed in writing on Form ANH-3-62-H.

2. Where possible, arrangements should be made to supervise the disinfection of all infectious cars received. Form ANH-3-62-C should be attached to the car only when disinfection has been personally supervised. Both sides of this form should be filled in, using weatherproof pencil, and a card attached to each side of the railroad car. Form ANH-3-62-B should be removed at the time Form ANH-3-62-C is attached.

3. Form ANH-3-62, Report of Infectious Cars Received, should be submitted to the Washington office of the Animal Health Division the day the car is received.

4. Form ANH-3-62-A, Report of the Disinfection of Infectious Car, should be submitted to the Washington office of the Animal Health Division the day the supervision of this work is accomplished.

5. Form ANH-3-62-D, Report of Delinquent Infectious Cars, should be submitted to the Washington office of the Animal Health Division on the 1st and 16th of each month, giving a list of all infectious cars reported on Form ANH-3-62 and not reported on Form ANH-3-62-A. No car should be included unless it was received 15 days or more prior to date of rendering Form ANH-3-62-D. A separate report should be rendered for each railroad company responsible for cars that are delinquent. No Form ANH-3-62-D is required on the 1st and 16th of each month unless there is an infectious car to report.

6. Charge for our service should be billed against the Animal Health Division on Form C&MS-488. The charge should include the time required for making telephone calls, preparing forms, and attaching placards. Travel expenses, if any, should also be billed against the Animal Health Division.

C. The forms used in performing this work are listed below:

ANH-3-62, Report of Infectious Cars Received.

ANH-3-62-A, Report of Disinfection of Infectious Cars.

Section 322.9(C)

ANH-3-62-B Placard, "Clean, Wash, and Disinfect This Car."

ANH-3-62-C Placard, "This Car Has Been Cleaned, Washed and Disinfected."

ANH-3-62-D, "Report of Delinquent Infectious Cars."

ANH-3-62-H, "Notice of Infectious Cars to be Cleaned and Disinfected."

322.10 Market Cattle Testing Program. Formal arrangements have been completed whereby the Meat Inspection Program will assume full responsibility for collecting blood samples for the Animal Health Division on a reimbursable basis from all properly identified cattle at packing plants under Federal inspection. Inspectors performing sample collections will record the number of samples collected on C&MS-488 in the "Blood Sample" column under the day collected.

The completed C&MS-488 should be forwarded to the Finance Division, Administrative Fiscal Branch, Hyattsville, Maryland, where it will be used as the basis for billing the Animal Health Division. For the most part, this sampling will pertain to mature cows bearing the official backtag but some exceptions may be made to this at a later date.

While you are no doubt familiar with most of the following, we are outlining the conditions under which Market Cattle Testing blood samples are to be collected and handled.

A. Cows to be sampled. Blood samples are to be taken from mature Market Cattle Testing backtagged cows as previously mentioned. Mature cows are defined as being three years of age or over and those less than three years of age which are parturient or post-parturient. Arrangements may also be made by the Animal Health Division to identify specific animals or lots by brands, ear tags, or by consignment papers. Blood samples would also be taken from these animals.

B. Collecting and handling the blood samples. Blood samples may be taken from the bleeding operation, the brachial plexus, the heart, or in any other way which will provide a good quality blood sample. About a half to three-fourths tube of blood provides the right amount for satisfactory laboratory handling.

C. Identifying the blood sample tube. This may be done by either removing the backtag and wrapping it around the tube or by recording the identification information on a record form. Every effort should be made to use methods for maintaining identification of the animal until inspection has been completed so that successful tracebacks may be made when lesions of tuberculosis or other disease conditions are found by post-mortem examination.

D. Handling and mailing the blood samples. Every precaution must be taken to avoid introducing moisture or contamination into the sample. The perishable nature of the blood sample must be fully recognized and refrigeration (35-40 degrees F.) must always be used for the blood samples after the serum has separated. When possible, blood samples should be mailed at the end of each day or at least every other day unless local arrangements are made for picking up the blood samples. Franked labels addressed to the proper laboratory will be provided for your use.

E. Maintaining supplies such as blood sample tubes, mailing boxes, franked labels, record forms, racks, etc. The Animal Health Division in your State will arrange for supplying these needs at each of the plants that are collecting Market Cattle Testing blood samples.

F. General provisions for program operation:

1. Arrangements at individual plants. It seems likely that Market Cattle Testing blood samples are now being collected at practically all federally inspected plants. Where this is not being done, local representatives of the Animal Health Division will make necessary arrangements with the packer to institute the program when the Animal Health Division feels it is necessary.

2. The Meat Inspection Program District Directors in each area will develop the necessary working arrangements with all of the plants in their region after the initial arrangements have been agreed to and by working closely with the Animal Health Division Directors in their respective areas.

In all of these arrangements, the Meat Inspection Program will act as an agent for the Animal Health Division in the collection of blood samples and related activities dealing with animal disease found on post-mortem inspection. It is expected that the Animal Health Division and the Meat Inspection Program will continue to cooperate closely in fully effecting these requirements. It is the intention of the Animal Health Division and the Livestock Slaughter Inspection Division to arrange for the collection of blood samples by Meat Inspection Program personnel at all plants under Federal inspection. This is to be done by mutual effort and planning between the Livestock Slaughter Inspection Division and the Animal Health Division as outlined herein.

322.11 The Meat Inspection Program will furnish assistance whenever requested by the Fruit and Vegetable Division in drawing official samples of processed fruits and vegetables at locations where personnel of that Division are not regularly assigned but where meat inspectors are working. Field officials of the Fruit and Vegetable Division will supply the necessary instructions at the time the request for drawing samples is made.

A charge for the time should be made on Form C&MS-488 in the regular manner showing under "Remarks" the type of service given and the name of the Branch of the Fruit and Vegetable Division that requested sampling.

322.12 Some stations have supervision over plants where both poultry and meat inspection are in effect may not have all printed material needed in order to do an effective job when performing poultry inspection. Several sets of such material have been obtained from the Poultry Division, Consumer and Marketing Service, and one set furnished each of the District Directors. Each set consists of a 24-page pamphlet entitled "Regulations Governing the Inspection of Poultry and Poultry Products." This is a reprint of Subchapter D, Chapter I, Title 7, of the Code of Federal Regulations. The effective date shown thereon is June 1, 1960. Poultry Inspector's Handbook. This is a loose-leaf 8x10 1/2 handbook of nearly 100 pages which deals only with the mandatory poultry inspection program. The material therein is numbered to correspond with the numbering of the Regulations. The handbook has been revised as of June 1967.

All of this material should be available at stations having meat inspectors who also perform poultry inspection, usually at plants where both poultry and meat inspection are in effect.

322.13 At establishments where a poultry inspector performs work on an overtime or holiday basis for the Meat Inspection Program, the poultry inspector should prepare Form C&MS-488 and reflect the hours in the column titled "Packer Overtime Act." The service should, of course, be charged against the establishment at which the work was performed.

The poultry inspector should at the close of each biweekly pay period mail the original and one copy of C&MS-488 to the Finance Division, Administrative Fiscal Branch, Hyattsville, Maryland, one copy to the Meat Inspection Administrative Staff, Consumer and Marketing Service, Washington, D. C. 20250. and the fourth copy should be retained in his files at the establishment.

322.14 Inspection of Food Suppliers for Interstate Carriers by U. S. Public Health Service. The interstate quarantine regulations of the U. S. Public Health Service provide for inspection of food sources supplying interstate carriers. Occasionally, this inspection will involve the review of establishments operating under Federal meat inspection. Inspectors will cooperate in any such survey at the request of the Public Health Service. If deficiencies are noted during this survey which come within your jurisdiction and responsibility, you should take prompt action to correct these deficiencies through the use of your authority over facilities, procedures and product in the official establishment.

You should not join with the inspection agency, however, in any critical report which might indicate the establishment is operating improperly. If conditions are found needing correction of a kind over which you have responsibility appropriate action should be taken. Continued violations of our regulations could be cause for a recommendation from you for the withdrawal of inspection. This would be expected only if you have exhausted your ability to obtain corrective action.

322.15 The Meat Grading Branch, Livestock Division, provides grading services at nonfederally inspected slaughtering and/or processing establishments only when they have been surveyed by an Officer in Charge and it is determined such plants (initially and throughout the desired period of use) are operating in compliance with the inspection and sanitation requirements of the Consumer and Marketing Service, Meat Grading Branch, as contained in SRA-C&MS 98 Section 53.6 with augmentation in pamphlet C&MS 322.

A. Request for Federal Meat Grading Service. Two forms are supplied to the applicant by the Meat Grading Branch:

1. Form LS-313, Application for Meat Grading or Acceptance Service (for use of Meat Grading Branch only).

2. Form LS-302, Report of Preliminary Investigation by Veterinarian, is executed by the local inspection system and is forwarded to the Livestock Slaughter Inspection Division by the Meat Grading Branch.

B. Action by Livestock Slaughter Inspection Division.

1. Reviews applicable laws, ordinances and regulations to determine conformity with C&MS requirements.

2. Reviews Forms LS-302 for completeness.

a. If it appears the establishment may be operating in compliance with C&MS Meat Grading Branch requirements, the Officer in Charge will be authorized to conduct an initial in-plant survey.

b. If Forms LS-302 show items of noncompliance, the establishment will be notified and the survey authorization deferred pending corrective action.

C. Action by Meat Inspection Program. On receipt of authorization a copy of Form LS-302 and applicable correspondence from the Livestock Slaughter Inspection Division, the Officer in Charge will perform an in-plant survey to determine if the establishment is operating in compliance with C&MS requirements.

1. Initial Surveys. On arrival at the establishment, the Officer in Charge should introduce himself to the management. Management and a responsible official of the local meat inspection system should be invited to accompany him on the survey. If an establishment representative and/or agent of the local inspection system are not available, the survey should be conducted in their absence. On completion of the survey, before leaving the establishment or the area, company management and local meat inspection officials should be furnished an oral summary of survey findings.

2. Compliance Status.

a. If plant is in compliance on an initial survey. On determining if the establishment is operating in compliance, the Officer in Charge will submit a written report containing his recommendation to the Livestock Slaughter Inspection Division specifying the operations for which the plant is to be recognized. The completed LS-302 should be given to the establishment. For purposes of expediency in securing grading service, the plant may wish to have favorable survey findings telephoned to the Livestock Slaughter Inspection Division. This may be done at company expense; however, such action must be followed by a written report.

b. If plant is NOT in compliance - on an initial survey. The Officer in Charge will submit a written report of his findings to the Livestock Slaughter Inspection Division (return the completed LS-302 with this letter). The report should detail all deficiencies under the following headings:

- (1) Ante-mortem and/or post-mortem inspection.
- (2) Sanitation.
- (3) Operations.
- (4) Facilities.

The report should include other pertinent information and/or conversation with management or inspectors.

3. Informal Visits to Local Meat Inspection System. The Officer in Charge may visit the office of the local inspection system to discuss progress being made in correcting previous survey deficiencies; however, he should not resurvey an establishment until authorized to do so by the Livestock Slaughter Inspection Division.

4. Request for Resurvey. When management of an establishment which was not recognized on an initial survey determines their operations have been brought into compliance with C&MS Meat Grading Branch requirements, they should inform the Livestock Slaughter Inspection Division in writing that:

- a. The deficiencies observed on previous survey have been corrected.
- b. A resurvey is requested.
- c. They agree to reimburse the Meat Inspection Program for all costs of the resurvey.

The company's letter must be accompanied by a letter of concurrence from a responsible official of the local meat inspection system. This should include an enumeration of corrective actions that have been made.

5. Resurvey Procedure. Authority to conduct a resurvey will be given the Officer in Charge by the Livestock Slaughter Inspection Division. A resurvey will be conducted in the same general manner as an initial survey with special attention given to previously observed deficiencies.

6. Report of Resurvey. The procedure outlined in C 2 a or C 2 b shall be followed.

7. Recognition of Compliance. After reviewing the initial survey or resurvey report, the Livestock Slaughter Inspection Division will inform the applicant by letter that his establishment is recognized to be in compliance with Consumer and Marketing Service, Meat Grading Branch, inspection and sanitation requirements. A copy of this letter will be sent to the Washington office of the Meat Grading Branch. The actual granting and initiation of grading service to a NFI establishment is the responsibility of the Meat Grading Branch.

8. Periodic Routine Surveys of Recognized Establishments. Form LS-4, "Plant Survey Report" is used for reporting these surveys. The form should be completed before leaving the establishment and copies distributed as follows:

- a. Original to establishment.
- b. Green copy to local inspection system.
- c. Green copy to local inspection system (if necessary).
- d. Yellow copy to Livestock Slaughter Inspection Division (showing copy distribution).
- e. Pink copy retained by Officer in Charge.

Deficiencies observed should be fully discussed with the establishment representative and responsible local inspection personnel, both of whom should be urged, in the interest of retaining recognized status of the establishment, to effect prompt correction.

9. Noncompliance in Recognized Establishments.

- a. If on a routine survey the Officer in Charge observed slaughtering operations being conducted in the absence of an official inspector he shall:

- (1) Complete his survey.

- (2) Orally apprise the plant management and a responsible local inspection official of the noncompliance with C&MS Meat Grading Branch requirements and probable loss of recognition.
- (3) Using other than plant phone, immediately notify the Livestock Slaughter Inspection Division.
- (4) Submit detailed report, via airmail, concerning the absence of the inspector and other deficiencies observed. This report should be prepared in a manner similar to C 2 b.
- (5) The Livestock Slaughter Inspection Division will:
 - (a) Immediately inform the establishment by wire that it is no longer recognized as being in compliance with the minimum inspection and sanitation requirements specified in SRA-C&MS 98. A copy will be sent to the Washington Meat Grading Branch office.
 - (b) After receipt of the written report and the official notice of withdrawal of grading service, write the plant detailing defects and deficiencies which led to loss of recognition and withdrawal of grading service. In addition, the letter will explain procedures for reinstatement of compliance recognition by the Meat Inspection Program.

b. If after previous fair warning, in those plants where facilities, sanitation and inspection procedures are not in compliance, the Officer in Charge shall:

- (1) Orally inform the plant management and responsible local inspection personnel of his observations and the possible loss of establishment recognition through failure to meet C&MS requirements.
- (2) Using other than plant phone, immediately notify the Livestock Slaughter Inspection Division.
- (3) Submit a detailed written report of all deficiencies to the Livestock Slaughter Inspection Division via airmail. This report should be prepared in a manner similar to C 2 b.

(4) The Livestock Slaughter Inspection Division will:

(a) Upon receipt of the report and determination of nonconformity immediately wire the establishment that it is no longer recognized as being in compliance with the minimum inspection and sanitation requirements specified in SRA-C&MS 98. A copy will be sent to the Washington Meat Grading Branch office.

(b) Upon receipt of the official notice of withdrawal of grading service, write the plant detailing the defects and deficiencies which led to loss of recognition and withdrawal of grading service. In addition, the letter will explain procedure for reinstatement of compliance recognition by the Meat Inspection Program.

c. The Livestock Slaughter Inspection Division will notify the Officer in Charge when a resurvey is to be performed.

d. Without exception, it is the responsibility of the Meat Grading Branch to actually withdraw grading service from or reinstate it to a nonfederally inspected establishment.

10. Reinstatement Resurvey. Follow applicable procedures in C 5 and 6.

11. Charges. Charges for surveys will be as prescribed in SRA-C&MS 98 and as shown in samples of C&MS Form 488 and LS Instruction 915 (MG)-3 (Rev. 2).

322.16 All special surveys requiring charges as specified in SRA-C&MS 98, Section 53.29 (e) shall be billed on Form C&MS 488.

It is imperative that we have a fair and realistic estimate of charges for our services. Therefore, it is necessary that the travel (includes mileage and per diem) and salary be prorated between Meat Inspection and Meat Grading activities. Travel costs should be prorated on the basis of the actual purpose of the trip. Salary costs should prorate the basic eight-hour day in accordance with the actual hours spent in reviewing activities. For example, if an Officer in Charge travels from Los Angeles, California, to Bakersfield, California, to visit one federally inspected and one nonfederally inspected plant (purpose 50% - 50%) spending two hours in each plant (actual hours worked 50% - 50%) the cost would be prorated 50 - 50 on both travel and salary.

A chart which shows hypothetical examples of how the time and travel should be prorated is on the reverse side.

Only actual cost of the travel and the salary for nonfederal plants should be furnished as separate items on the reverse side of each LS-4 (yellow copy) which is submitted to the Livestock Slaughter Inspection Division; i.e.
Travel \$ _____. Salary \$ _____.

PRORATION OF TRAVEL AND SALARY IN REVIEWING NONFEDERALLY INSPECTED ESTABLISHMENTS

<u>From</u>	<u>Purpose of Trip</u>	<u>Hours Worked</u>				<u>Charges</u>			
		<u>FI</u>	<u>NFI</u>	<u>FI</u>	<u>NFI</u>	<u>Travel</u>	<u>Salary-Hours</u>	<u>FI</u>	<u>NFI</u>
Official station	1 FI Plant	6		100%		100%		8	
Official station	1 NFI Plant		5			100%			8
Official station	1 FI Plant & 1 NFI Plant	3	1	50%	50%			6	2
Official station	3 FI Plants & 1 NFI Plant	6	2	75%	25%			6	2
Official station	1 FI Plant & 6 NFI Plants	8	8	1/7	6/7			8	8
Official station	1 NFI Plant (Had time to make short review of FI Plant)	1	7			100%		1	7

Key

FI Federally Inspected
NFI Nonfederally Inspected

NOTE: If GSA automobile is used and the purpose of the trip is 100% for review of NFI plant or plants, the entire cost for use of GSA automobile will be charged to the plant or prorated to those reviewed if more than one. Only those travel expenses would be included that is claimed on a Travel Voucher. Fractions of hours should be rounded out to the nearest hour.

If more than one NFI plant is to share the estimated cost, the proportionate charges for each plant shall be shown on the respective LS-4 yellow copy.

PART 323 - BRIBERY, COUNTERFEITING, ETC.

323.1 It is essential that each employee be aware of the standard of conduct expected. To accomplish this, each Officer in Charge and Chemist in Charge should take specific action in this area by discussing the conduct requirements outlined in C&MS Instructions 363-1, 365-1, 365-3 and 366-1 with each employee at his Circuit. At large Circuits this may be delegated to Subcircuit supervisors. During such discussions, emphasis should be placed on two types of prohibited conduct which are of special importance in the performance of the responsibilities assigned to this Program. These relate to the acceptance of gratuities in any form from inspected packers or others whom we service and the willful falsification of official records including time and attendance reports. It should be further emphasized that misconduct in these two areas normally results in a recommendation for the removal of the employee involved.

These discussions should take place annually at the time of the performance rating interviews. Your Circuit files should contain a record signed or initialed by the employee indicating when these discussions took place. In addition to recording the annual discussion, it is essential that each new employee be informed during the orientation period of these requirements and the record completed in the same manner.

323.2 All cases of attempted bribery of Meat Inspection Program employees should be reported immediately to the nearest FBI field office or agent. In no case should more than one hour elapse from the time of the event until the case is properly reported.

Successful investigation and resultant prosecution is often dependent on immediate referral of such cases in order that leads can be covered and necessary evidence preserved. Employees should avoid making a commitment to the individual offering the bribe and follow advice of the investigative agents.

At appropriate times, Officers in Charge should discuss the matter with their employees and decide as to who will actually make the FBI contact.

The address as well as the telephone number of the FBI field office or agent is found in that part of the telephone directory concerning the United States Government. This information should be kept readily available. If there is none listed in the local telephone directory, contact should be made with the local police for the address and telephone number of the nearest FBI office or agent of the FBI.

Employees should report all such cases to their Officer in Charge who, in turn, will report to the Washington office and the appropriate District Director. The Washington office will advise the Office of Personnel through the Personnel Division of C&MS of the incident and the action taken.

PART 324 - EXPORT STAMPS AND CERTIFICATES

324.1

A. An inventory and control of export certificates and stamps will be in effect at all Circuits. The accounting system should reconcile all certificates and stamps received with those that have been issued or voided and those remaining on hand. Certificates and stamps and pertinent inventory records must be maintained under official lock or seal.

A responsible inspector at each establishment must maintain a record of all export stamps and certificates received and issued to applicants. The record should include all pertinent information concerning the export shipment. This establishment record should be reconciled with the Sub-Circuit and Circuit inventory to assure adequate inventory control. Frequency of reconciliation will be determined by Officer in Charge.

B. A good adhesive suitable for the purpose should be used to affix export stamps securely to containers. Some adhesives suitable on wooden boxes may not be satisfactory on metal containers. Also, the handling that the articles are to receive, such as freezing, will determine the kind of adhesive to use. It has been found desirable to apply a thin covering of adhesive over the export stamp as an added protection.

324.2 When U. S. Inspected and Passed product is processed in other than an official establishment, it loses its identity as such and is no longer considered inspected and passed product. It is not eligible for export certification as such.

324.3 The extent of reinspection of product being shipped for export depends on the type of product, container thereof, and size of the order. Sample inspection might suffice, or 100 percent inspection may be necessary. The inspector must make such inspections as will assure him of the facts upon which he makes the export certification. Frozen product may be inspected by defrosting boxes of product or by removing center slices of the product for defrosting.

324.4 The inspector is to prepare the certificate. He may allow the establishment to type the certificate if he personally supervises the typing. The foreign destination should be shown on the export certificate. The original export certificate should be signed in ink.

324.5 The packing of inspected and passed product in cartons or containers for export at places other than official establishments should be done under the Identification Service.

324.6

A. It is not necessary to furnish more copies of official export certificates than is provided for in the Regulations. Exporters may make photostats of the completed certificates.

B. Restrictive statements such as "Lymph Nodes on" and "Lard, Current Production," should not be added to the name of the product on the regular export certificate unless they are provided for in the Meat Inspection Regulations, Manual of Meat Inspection Procedures, or have been previously authorized by the Processed Meat Inspection Division. Such statements should not appear on the certificate simply because the exporter included it on his export certificate request, Form MI-412. Requests for all additional certifications not authorized are to be referred to the Processed Meat Inspection Division.

324.7 Officers in Charge are authorized to comply with requests to inspect and certify for export product, previously inspected and passed and so marked, which is located elsewhere than in an official establishment. This may be done whether the product is within reasonable geographic limits of the Circuit, or located geographically so that the export certification might have logically been handled by another Circuit. In the latter case, the availability of an inspector must necessarily be considered. If the workload at a small Circuit is such that requires constant attention of the personnel assigned so that a request cannot be complied with, then the applicant should be asked to submit his request to the Officer in Charge of a larger Circuit where personnel would be available, or to the District office. Where warranted, an Officer in Charge may transmit such request, with his comments, to the District office. The party requesting the service is to reimburse the meat inspection appropriation for the expenses of travel, subsistence, and any overtime that an inspector incurs while away from his official station, but no charge shall be made for the base time of the inspector.

324.8 Certification of inedible material for export (such as fertilizer, dried blood, bonemeal, and the like) that includes a description of the method of processing and handling, the temperature to which the article has been heated, and the length of time maintained, can be performed under the Certification Service for Inedible Animal Byproducts administered by the Animal Health Division. (See ANH Division Memorandum 592.1).

When this material is prepared or handled in an official establishment, the Animal Health Division has asked us to act for them. For this purpose, a letterhead type of certificate should be used. This should show that the certification is by the Animal Health Division with the Officer in Charge acting for them. The Washington Staff of the Animal Health Division will deal directly with Officers in Charge about this problem and furnish instructions to carry out the functions.

Charges for the service should be billed against the Animal Health Division and should include the time needed to complete the transaction, including the time of the inspector supervising the processing or preparation of product and time of anyone making out and handling the certificates. A minimum charge of 15 minutes should be made for each separate billing transaction, which means each time a certificate is issued. If supervision of a particular item covers more than one day, the charge may be made on the last day.

324.9 It is the responsibility of exporters to determine the requirements of a foreign country. The following requirements have been brought to the attention of the Processed Meat Inspection Division, and are reproduced for the information of exporters and Meat Inspection personnel.

A. The official meat inspection seal, United States Department of Agriculture, will be used on MI-412-8 and MI-412-9.

B. Blue animal casing certificate (MI-415-4) may be issued to any country on request of exporters.

C. Numbered inedible product stamps, MI-415-6, and inedible product certificates, MI-415-3, may be issued upon request of the shipper for export shipments of casings, bladders, hoofs, horns, grease, and similar animal products.

D. Certifications and statements marked * will be made only at the request of the establishment or exporter. Charges will be made against the applicant for all additional time needed to develop the facts or supervise the product under the Certification Service (Part 340, Meat Inspection Regulations), or the Certification Service for inedible animal byproducts administered by the Animal Health Division (Part 324.8. Manual of Meat Inspection Procedures).

324.20 ALGERIA

A. Meat Products

1. Issue Form MI-412-11.

B. Casings

1. Form MI-412-11 may be issued.

324.23 ARGENTINA

A. Meat Products

1. Export certificate shall be visaed by consul of that country.

324.25 AUSTRALIA

A. Meat Products

1. Fresh and frozen meat and meat products are not eligible for exportation to Australia at this time due to the existence of hog cholera in this country.

2. Cooked meats and cooked meat products contained in hermetically-sealed cans may be exported accompanied by the following certification signed by an authorized government veterinarian:

a. The goods were derived from animals slaughtered for human consumption in the United States.

b. The animals from which the goods were derived were subjected to ante-mortem and post-mortem veterinary inspection at the time of slaughter and were free from contagious and infectious disease.

c. The goods were not exposed to infection prior to exportation.

3. In addition, the following declaration by the manufacturer is required:

a. In the course of manufacture, every portion of the contents of the cans or tins has been heated to a temperature of not less than 100° C. (212° F.).

b. The temperature of the heat used for that purpose and the length of time for which it was used has been endorsed by a government veterinary officer in the United States with a certificate certifying that he is familiar with the process of manufacture of the goods and that he has no reason to doubt the truth of the declaration.

B. Casings

1. Issue Form MI-415-5.

C. Inedible

*1. Cattle hides are not permitted entry from countries in which foot-and-mouth disease occurs. They must be accompanied by a certificate from a government veterinarian stating that the hides were derived from cattle slaughtered for human consumption.

324.27 AUSTRIA

A. Meat Products

1. The following statement will be made either on the reverse of the regular export certificate or on Department letterhead stationery: "This is to certify that neither rinderpest, foot-and-mouth disease nor contagious pleuropneumonia existed in the United States during the twelve months preceding slaughter of the animals from which these products were derived."

B. Casings

1. Issue Form MI-415-5.

324.31 BELGIUM

A. Meat Products

1. Issue Form MI-412-8.

2. The Belgium meat import regulations apply to all meat including horse meat, and all processed and canned products containing more than 5 percent by weight of meat.

3. The following fresh or frozen products are eligible for entry:

a. Beef -- bone-in or boneless pieces weighing at least 22 pounds.

b. Veal -- bone-in pieces weighing at least 22 pounds.

c. Pork -- bone-in hams, loins, and bacon from back and breast.

d. Mutton, Lamb & Goat -- bone-in legs, shoulders and loins.

e. Horse meat -- bone-in pieces weighing at least 22 pounds.

f. Unboned heads of all species.

g. Edible offal, such as hearts, kidneys, livers, tongues, brains, intestines, paunches, stomachs, bowels, pancreas and thymus. (Bowels, paunches, and stomachs must be scraped and scalded.)

4. Fresh meat, chilled or frozen, shall be marked with clearly legible brands. Each piece or cut shall be branded. Carcasses weighing less than 132 pounds shall have four brands on the shoulders and external surfaces of the hind limbs. Pork carcasses shall also be branded on the ribs. Carcasses weighing more than 132 pounds shall have at least four brands on each side placed on the thigh, loin, back and shoulder.

5. Labels need not be submitted to the Belgian officials for approval but shall be approved in the usual manner by the Labels, Standards, and Packaging Branch, Technical Services Division. One label shall be affixed to the container and one label shall be placed inside the container. A label need not be placed inside the container if the cans or packages within the container all bear labels identical to the label affixed to the container. The label shall show:

- a. Kind of meat in the product,
- b. Official number of the plant processing or producing the product, and
- c. Country of origin.

B. Casings

1. Containers may be marked with blue animal casing stamp (MI-415-7). Each exportation shall be covered by Form MI-412-8 with words "Animal Casing" substituted for the word "Products." The certificate must bear the serial numbers of the casings stamps used. Nodular casings shall be described on the certificate as "Nodular (not clear)."

324.37 CANADA

A. Meat Products

1. Certificate (Form MI-412-3) should show the official number(s) of the establishment(s) in which the product was prepared and the address of consignor for products exported to Canada.

2. Livers are required to have portal lymph glands intact. Sliced liver in consumer-size packages accepted without the portal gland. Beef livers without portal lymph glands, shipped at the exporter's risk, should bear the statement "Beef Livers (not certified for presence of portal lymph glands)" on the export certificate.

3. Meat trimmings too small to permit adequate inspection are not permitted.

4. Dressed carcasses from which the peritoneum, pleura, or body lymph glands have been removed are not permitted.

5. Artificially colored product prohibited.

6. Spleens, udders, mucous membranes, parotid salivary glands, and lungs are prohibited in meat food products.

7. Any descriptive terms applied to meat products and composition of meat products must be consistent with the Canadian Food and Drug Regulations and the Canadian Meat Inspection Regulations.

8. Foreign products originating in countries other than Argentina, Australia, Brazil, Denmark, France, Federal Republic of Germany, Republic of Ireland, Netherlands (Holland), New Zealand, Northern Ireland, Norway, Paraguay, Poland, Portugal, Scotland, Sweden, Switzerland, United States of America, Union of South Africa, and Uruguay are not permitted entry into Canada.

9. Bulk products such as fresh hams, bellies, etc., may only be shipped from official establishments in this country directly to registered establishments in Canada. If this is not the case, products of this nature must be placed in packages such as cartons or boxes bearing markings approved by the Canada Department of Agriculture. Each bulk piece must be legibly branded with the inspection legend of an official establishment. There must be at least three brands to each hog side. Skinned bacon bellies may be bundled and tagged. The tags should bear all the required labeling features including an inspection legend. The mandatory information for loose or bulk meat must appear on a placard 12" by 12" on the doors of railroad cars, trucks, or trailers and shall show the following:

a. The name and address of the packer or first dealer. The address shall include the abbreviation U.S.A. In the case of a first dealer or distributor, the name shall be preceded by the words "Packed for."

b. A true and correct description of the contents. The animal species must be shown as well as the cut or portion name.

c. The statement "Product of U.S.A." must appear immediately below the product description in a clear and legible manner which usually requires that it be in letters at least half the size of those used in the product name.

d. Net weight and the word "weight" must be spelled in full.

e. The official serially numbered Form MI-412-10 (Export Stamp) is to be attached. For approval purposes the domestic meat label is acceptable provided it is indicated that the official export stamp will be used on the actual shipment.

10. A similar placard is expected for beef quarters, skin-off calf carcasses and hog carcasses. However, in the case of skin-on calf carcasses, an approved individual carcass tag is required in lieu of external branding.

11. Meat inspected or identified under Part 340 of the Regulations is not eligible for entry into Canada according to their standards.

12. Boars are not eligible for entry. Inspectors are to make a reasonable effort to assure that pork from boars is not certified to Canada. This is particularly important in pork from establishments that slaughter a high percentage of boars.

B. Casings

1. Issue Form MI-415-5 in duplicate. Show the official number(s) of the establishment(s) in which the product was prepared, and the name and address of the consignor for products exported to Canada.

2. Animal casings must have been slimed and stripped so that the mucous lining is completely removed by means other than fermentation. Markings must be approved by the Canadian Veterinary Director General.

C. Inedible

*1. The following statement will be made on Form MI-415-3; "The material described on this form originated in an establishment operating under U. S. Federal inspection and was derived from animals that received ante-mortem and post-mortem inspection and were found to be free of disease at time of slaughter."

324.43 COLOMBIA

A. Meat Products

1. Certificate should be visaed by consul of that country at place of origin or first port.

2. Form MI-412-7 issued in five copies for lard destined to Colombia. The fifth copy is for the Circuit file.

324.49 CZECHOSLOVAKIA

A. Meat Products

1. The following certification, on the reverse of the regular export certificate or on Department letterhead stationery, may accompany lard:

a. Originates from hogs which were found to be healthy before, during and after slaughter, and that the meat, including fat, is suitable for human consumption without any restrictions.

b. No antioxidants were used in producing the lard.

324.53 DOMINICAN REPUBLIC

A. Meat Products

Section 324.53(A)

1. Export certificate to be visaed by consul of that country at place of origin or first port.

324.55 ECUADOR

A. Meat Products

1. Certificate to be visaed by consul.

324.61 FRANCE

A. Fresh Meat Products

1. Form MI-412-11 is to be used to certify fresh meats and offal items for export. Packages of meat, meat food product or edible offal must be identified with duplicate labels, serially numbered. One label is to be applied to the outside of the container and the other to the interior of the package. The label must show the following details:

a. A serial number.

b. A description of the product including the species of animal from which derived.

c. Net weight.

d. Inspection legend. The inspection legend is to be the labeling legend illustrated in Section 317.2 of the Regulations.

2. Item 2 of the MI-412-11 "Address of the approved slaughterhouse or houses" should show the establishment in which the product was last handled or packed, irrespective of the type of operations conducted by the establishment.

3. Pork and pork variety meats must not be derived from hogs coming from herds or farms under quarantine for hog cholera. A statement to this effect must appear on the MI-412-11 as follows:

Ces produits de porc ou d'abats de porc ne sont pas de provenance d'animaux eleves dans une zone en quarantaine pour peste porcine.

4. Pork and pork cuts may be certified for export if frozen for destruction of trichinae as follows:

a. 30 days at -15° C. ($+5^{\circ}$ F.)

b. 20 days at -23° C. (-9.4° F.)

c. 12 days at -28° C. (-18.4° F.)

Bulk product may be stored, trichinae treated and packed for export to France in a cold storage plant operating under Identification Service. In these cases, the labels (interior and exterior) will bear an inspection legend with an establishment number in the 3000 series. The French Sanitary Certificate, Form MI-412-11, must show the name, address and establishment number of the producing establishment as well as the name, address and establishment number of the cold storage plant.

5. Cuts of meat, boneless or bone-in, weighing more than $6\frac{1}{2}$ pounds must be branded.

6. When small cuts of less than $6\frac{1}{2}$ pounds are wrapped or packaged, the wrapping or package should show the following:

- a. Name, location and license number (inspection legend) of preparing establishment.
- b. Species of animal and name of cut.
- c. Net weight.
- d. Date of packaging.

7. Individual packages or cuts of meat are to be in containers showing the following:

- a. Name, location and license number (inspection legend) of the preparing establishment.
- b. Species of animal and name of cut.
- c. Net weight.
- d. Date of packing or date of deboning.

*8. Beef and sheep livers must be inspected by the following procedure:

- a. The bile duct will be opened by the usual method.
- b. A transverse incision will be made across the omasal impression of the visceral surface of the liver sufficiently deep to cut the smaller branches of the bile duct.
- c. A second transverse incision will be made across the visceral surface of the liver from beside and below the caudate lobe; again cutting the smaller branches of the bile duct.

This procedure is identical to the one required on beef and sheep livers exported to Germany. Location and extent of the incision are illustrated in photographs reproduced in Section 324.65, Germany.

*9. Pork livers must be inspected by the following procedure:

- a. Livers will be observed and palpated by the usual inspection method.
- b. Hepatic lymph nodes are to be attached and incised by a number of incisions.

B. Processed Meats

1. Form MI-412-12 is to be used to certify all processed meats, including edible fats, for export to France. The official meat inspection seal should be placed on the lower left portion of the certificate. It is not necessary for packaged and labeled product certified with this form to have labels inserted in the shipping containers.

2. All canned or frozen meat or meat food products in containers to be sold at retail or institutional levels are to be marked with the date or code date of packing. The date marking of the packages or cans may be either in clear figures or shown in code. If it is shown in code, the code must be provided to the French Ministry of Agriculture by the exporter or his French Agent. The code information should be directed to the Service da La Reprission des Fraudes, Ministere de l'Agriculture, Paris, France. Frozen product such as variety meat and edible organs imported in large packages (bulk) are not covered by this requirement.

C. Casings

1. Form MI-412-12 is to be used with meat inspection seal impressions.

2. Casings may be certified from unofficial premises if the following conditions are met:

- a. The establishment preparing the casings is open at all times to Federal meat inspectors.
- b. Inspections are made periodically to insure that proper standards of hygiene are maintained.
- c. The casings are obtained from animals slaughtered under Federal meat inspection.
- d. The inspected plants from which the casings are obtained are recorded under Item 11 "Origin of the foods."

324.65 GERMANY (WEST GERMANY)

A. Meat Products

1. Issue Form MI-410-10 for fresh meats and edible organs.

2. Form MI-410-12 will accompany all shipments of pork certified for export to Germany. It will be issued in addition to Form MI-410-10. To issue MI-410-12 the following criteria must have been satisfied: (a) Hogs are satisfactorily identified to the inspector as coming from states having a quarantine program for brucellosis and cholera; (b) hogs do not originate from quarantined brucellosis or cholera herds; *(c) identity of eligible product is maintained until packed for export. Porcine infectious encephalomyelitis and foot-and-mouth disease do not exist in the United States.

3. Form MI-410-13 will accompany all shipments of beef and beef products certified for export to Germany. It will be issued in addition to the German Meat Inspection Certificates, Form MI-410-10. Beef and beef variety meats derived from animals originating in modified certified areas and certified brucellosis-free areas will qualify under Section III (1) (d) of the German Animal Health Certificate. Establishments should contact Federal and/or State veterinary animal disease control officials regarding the feasibility of obtaining the brucellosis certification.

4. It is no longer necessary to record dates of slaughter on Form MI-410-10 or dates of production on Form MI-410-11.

5. Chilled, skinned, veal carcasses weighing no more than 165 pounds may be shipped in halves or quarters without heads.

6. Fresh pork tongues and fresh beef tongues are not eligible for shipment.

7. Fresh pork fatbacks or pork bellies may be shipped in pieces weighing at least 7 pounds. Fatback with rind removed must be packed with five pieces to a package. Each package shall be labeled according to B 2 of this section.

8. Products intended for export to Germany must be stored either in official premises or in warehouses operating under the Identification Service.

9. Heads, tongues, hearts and lungs shall be marked with a color or burning brand. Tongues and hearts of cattle less than 3 months old and tongues and hearts of hogs, sheep and goats need not be marked. Parts other than ends of extremities shall be marked with a color or burning brand.

10. Labeling

a. Bulk Packages and Shipping Containers

Bulk packages and shipping containers of meat, meat food products and offal must have an approved label affixed in a way that it is clearly visible. The label inspection legend must be placed so that it will be destroyed on opening of the package. Therefore, the labels should be applied to the cartons at the junction of the closed lid flaps or the junction of top and bottom on telescope cartons.

Labels must show the following details:

- (1) Serial number.
- (2) Inspection legend with establishment number.
(Labeling legend)
- (3) Product name.
- (4) Species of animal from which derived.
- (5) Net weight.
 - (a) Labels of consumer packages must show the weight of meat or meat filling (including sausage) at time of packaging or canning.
 - (b) If meat contains bone or loses weight from further processing after packaging or canning, a statement to this effect is required on the label.
 - (c) If the product contains ingredients other than meat, total net weight is also required on the label. Liquid or concentrated meat soups may have the volume stated on the label in lieu of total net weight.

b. Consumer Packages

Production Dates

- (1) Meat products in consumer packages which are capable of storage without refrigeration for a minimum of one year must carry the year of production such as "1967." It may be stamped or embossed on the can or package. Coding is not allowed.
- (2) Processed meat products in consumer packages which are deep-frozen and labeled as such, as well as salami-type sausages and cured cooked meats such as ham must carry the month and year of production such as "9-67." The label should read: "Hergestellt am ____" (manufactured on). Coding is not allowed.
- (3) Fresh, frozen meat products in consumer packages must carry the day, month and year of production in that order such as 26-9-67. The label would read: "Hergestellt am ____" (manufactured on). The packages also carry the German statement "Auch bei Kuehlung nur begrenzt haltbar." This means that shelf-life is limited even when refrigerated.

11. Frozen cattle carcasses may be shipped in quarters without heads. Beef and veal carcasses are permitted entry either with or without kidneys and kidney fat. If kidneys and kidney fat are attached, the kidneys must be exposed. Quarters and halves of all species must be marked to identify whole carcasses. Carcasses weighing over 130 pounds shall have each half branded on the outer side of the round, loin, belly, shoulder and pleura surface of the ribs. Those weighing less than 130 pounds shall be branded on each shoulder and outer side of each round.

12. Hog carcasses may be shipped in halves. The head must be split and left attached. The sides must be marked to identify whole carcasses. The tonsils, eyeballs and eardrums must be removed. (Note: We cannot at present provide the animal health certificate for hog brucellosis required for importation of pork into Germany.)

*13. Beef and sheep livers. The bile duct will be opened by the normal method. In addition, a transverse incision will be made across the omasal impression of the visceral surface of the liver sufficiently deep to cut the smaller branches of the bile duct. A second transverse incision will then be made across the visceral surface of the liver from beside and below the caudate lobe again cutting the smaller branches of the bile duct. The photographs, at the end of this section, illustrate the location and extent of these incisions.

*14. All livers. Hepatic lymph nodes are to be attached and incised by a number of incisions. Livers shall be marked with a burning brand.

B. Processed Meat Products

1. Issue Form MI-410-11.

2. Labeling requirements as outlined in A(10) "Meat Products" also apply to processed products.

3. The German law defined processed meat as having been treated by one of the following methods:

- a. Heating to a minimum internal meat temperature of 149°F. (65°C.)
- b. Pickling or curing so that the meat contains at least 4 percent salt.
- c. Rendering of fats.

*4. Beef tongues intended for cooking must be incised on the lower side from the tip to the base as a further examination for cycticercosis.

*5. Lard must be prepared without refining. The following may be added to lard in unspecified amounts and without declaration: sodium citrate, ascorbic acid, sodium ascorbate, erythorbic acid, sodium erythorbate, tocopherols with acetic acid and with fat forming fatty acids such as steric, oleic, linoleic, linolenic, palmitic and myristic. Laboratory samples should be submitted for the presence of BHT, BHA, and gallates which are prohibited additives. They should also be submitted for peroxide values which should not exceed 4. Samples should be taken from the final package, such as drum, box, etc. A sufficient number of samples should be taken to get a representative picture of the shipment. For example, if the lard is derived from a single lot or holding tank it is suggested that 8 or 9 of the drums should be sampled. One of the samples should be taken from the first lard drawn. Equal portions of 4 of these single samples (not more than 4) can be combined in a composite sample. The lard shall not be older than 8 weeks from time of production to time of export. It may be exported only in the following containers:

- a. Wooden boxes holding 25 kilograms (approximately 55 pounds) with one partition forming two 12.5 kilogram parcels. The wooden boxes must be lined with impermeable paper so as to cover the commodity completely.
- b. Carton holding 10 kilograms (approximately 22 pounds). The carton must be made of impermeable material or be lined with paper as in "a."
- c. Metal drums of approximately 180 kilograms capacity (approximately 397 pounds), the inside walls of which are of acceptable noncorrosive material.
- d. The restriction on antioxidants in lard may be waived for special purchases of lard intended for Berlin storage purposes when specifically requested by the foreign importer. The certificates for these shipments containing BHA, BHT, and/or gallates should be modified by including a statement indicating the presence of the antioxidants and the amounts added.



Incising Visceral Surface of Liver Below Caudate Lobe



Incising Omasal Impression of Visceral Surface of Liver

324.68 GREAT BRITAIN - UNITED KINGDOM

A. Meat Products

*1. Cooked pork may be exported without restriction. This includes all pork products that do not have to be further cooked to be consumed. Hams are under a quota and hence their importation is restricted.

2. Fully cured bacon and ham may be exported from the U.S.A. to Great Britain for consumption in U. S. Force troop messes (including officers and NCO messes) or for resale in U. S. Force commissaries under a license issued by the British Ministry of Agriculture, Fisheries and Food.

Each consignment must be accompanied by a certificate signed by a duly authorized officer of the United States Federal Government describing fully the process of curing to which the product has been subjected, which shall be one of the following:

- a. Pumping with brine under a pressure of 80 pounds or more to the square inch and subsequently soaking in brine or dry salting for a period of not less than four days.
- b. Salting (wet salting or dry salting) for a period of not less than ten days.
- c. Each consignment must be accompanied by a certificate signed by a duly authorized officer of the U. S. Federal Government, certifying that the hogs from which the meat is obtained were derived from and slaughtered in a state participating in the United States Hog Cholera Eradication Program.

3. Fresh and processed pork products (excluding fully cured bacon and ham) may be exported from the U.S.A. to Great Britain for consumption in U. S. Forces troop messes only under a license issued by the British Ministry of Agriculture, Fisheries and Food.

- a. The refrigerated pig meat and processed pig products shall comprise any or all of the following items which will not require trimming or processing before being cooked: Pork loins, spare ribs, Boston butts, and ready-to-eat sausage containing pork.
- b. Each consignment must be accompanied by a certificate signed by a duly authorized officer of the U. S. Federal Government, certifying that the hogs from which the meat is obtained were derived from and slaughtered in a state participating in the United States Hog Cholera Eradication Program.

- c. That the refrigerated pig meat and processed pig products come from slaughterhouse subject to Federal meat inspection and processed products (such as sausages) from processing plants which obtain meat exclusively from federally inspected plants.
- d. The refrigerated pig meat and processed pig products shall be packed in leakproof containers.
- e. Refrigerated pig meat and processed pig products from the United States shall be consumed in American Forces messes (in recognized American Camps) and shall not be removed from these messes for any purpose whatsoever.
- f. Packages of refrigerated pig meat and processed pig products shall be kept hard frozen until taken into the mess kitchens for defrosting immediately before cooking. All wrappings, including leakproof containers, shall be destroyed on the camp site by burning.
- g. All swill shall be disposed of solely to the collectors approved by the Minister of Agriculture, Fisheries and Food.

*4. Livers, with the exception of lamb livers, must have the hepatic lymph nodes attached.

5. The following is prohibited importation:

- a. Scrap meat -- Meat which consists of scraps, trimmings, or other pieces (with or without bone), of such shape or in such condition as to afford insufficient means of identification with a definite part of a carcass.
- b. Meat comprising the wall of the thorax or abdomen from which there has been detached any part of the pleura or (except in the case of meat derived from a pig) the peritoneum, other than a part necessarily removed in preparing the meat.
- c. Meat other than mutton and lamb from which a lymphatic gland, except a gland necessarily removed in preparing the meat, has been taken out.
- d. The head of an animal without the submaxillary gland.

6. At the exporter's request, lard destined to England and Scotland may be loaded in ships' tanks that have not been inspected for cleanliness by meat inspection personnel. The export certificate issued for these shipments will be properly qualified with a statement indicating the tankers were not inspected for cleanliness by the meat inspection personnel.

a. An inventory of U. S. Inspected and Passed lard or rendered fats will be maintained when these products are handled under the Identification Service. This will include additions to and removals from each tank. The inspector should be able to estimate the amount of product in storage at all times.

b. An inspection opening will be required on each tank. The connection of the tank to any line will be broken by the removal of a 1-foot section of pipe at the time the tank is sealed. Transfer from the tank to the ship will only be permitted through a line having no other connections than to the tank. Otherwise the transfer will be accomplished by tank trucks.

c. The ships' tanks should be examined to ascertain they are empty before operations are started. If operations are interrupted for any reason, the hatch on the tanker will be sealed and not broken until operations are resumed under supervision. Whenever possible, weights should be checked with the marine surveyor.

d. One export stamp, Form MI-412-10, should be issued for each ships' tank that is utilized. The stamps should be applied to the tanks.

*7. Edible fats and oils exported to the United Kingdom may contain antioxidants in the following amounts:

Propyl gallate, octylgallate, dodecylgallate, or any mixture of the three -----	100 ppm
Butylated hydroxyanisole (BHA) -----	200 ppm
Butylated hydroxytoluene (BHT) -----	200 ppm
Any Mixture of BHA and BHT -----	200 ppm
Citric Acid -----	100 ppm

The label on product containing antioxidants must include a description of the antioxidant and the maximum amount expressed in parts per million.

8. These procedures shall apply to packing "papain" kidneys as edible product. The packer shall:

a. Obtain kidneys from inspected and passed papain - treated carcasses.

b. Handle kidneys as edible product.

*c. Maintain identity of kidneys until packed for export.

d. Label containers "Beef Kidneys - Tendered with Papain - For Export Only."

9. The following statement is to be added to the reverse side of the export certificate for products other than pork: "I certify this shipment contains no pork meat and product is derived from an abattoir operating under Federal meat inspection.

Signed "

10. After April 1, 1967, the United Kingdom authorities will recognize the Federal meat inspection legend, including the establishment number of the producing plant, as being the "official certificate" for the importation of all product from the U. S. in place of the regular export stamp, Form MI-412-10. The mark of inspection is to be a printed inspection legend in the form illustrated in Section 317.2 of the Meat Inspection Regulations. It will, however, be necessary to continue using Form MI-412-3, Regular Export Certificate, and Form MI-412-10, Export Stamp, for all meat, meat food products and meat byproducts intended for export to the U. K. This is necessary to comply with Section 324.3 of the Meat Inspection Regulations.

Bulk animal fats to be exported in ships' tanks must be accompanied by an approved label for the product bearing the inspection legend, including the establishment number of the producing plant. Where the product originates from more than one establishment, there must be a label from each producing plant. Bulk lard and other rendered animal fats shipped from Identification Service installations may be accompanied by a label for the product approved for the installation. The inspection legend will include an establishment number in the 3000 series.

The label or labels for bulk fats should be attached to the export certificate, Form MI-412-3, which should accompany the shipment. The exporter should deliver the certificate with the attached labels to the cargo officer of the ship.

B. Casings

1. Must be identified by a label with an inspection legend approved for the casings and attached to the container. The inspection legend shall include an establishment number in the 3000 series. (Food Inspection Service). To be eligible for the mark of inspection, the casings must be:

- a. Handled in a sanitary manner.
- b. Derived from federally inspected establishments.
- c. Packed under the Food Inspection Service.

2. Upon request of the exporter, Form MI-415-5, Special Export Certificate for Animal Casings, may be issued in duplicate to cover each exportation.

324.69 GREECE

A. Processed Meats

1. To export canned meat and canned meat food products to Greece, the following certifications are to be made on the back of MI-412-3 and signed by the inspector:

- a. "These products were derived from _____.
(species of animals).
- b. "These products have been inspected at loading and found wholesome."
- c. "These products are marketed in the same form and composition in the United States."

2. The following must be shown on the can or its label. Code markings may be used provided the code identification is furnished the Veterinary Service, Greek Ministry of Agriculture:

- a. Country of origin and name of manufacturer.
- b. Name of canned product.
- c. Statement that can is sterilized (shelf stable) or pasteurized (perishable). If sterilized, the date of preparation; if pasteurized, the date of preparation and a maximum time limit of two years within which the product may be marketed for consumption.

324.71 GUATEMALA

A. Meat Products

- 1. Export certificate to be visaed by consul of that country.

324.74 HAITI

A. Casings

- 1. Export certificate to be visaed by consul of that country.

324.76 HONG KONG

A. Meat Products

1. Regular export certificates will be issued for all export shipments to the Crown Colony of Hong Kong.

- 2. The following are refused entry:

Section 324.76(A2)

- a. Scrap meat; i.e., meat which consists of scraps, trimmings, or other pieces (with or without bone) of such shape or in such condition as to afford insufficient means of identification with a definite part of the carcass.
- b. Carcasses from which the pleura or peritoneum (except pigs) has been removed.
- c. Meat without skeletal lymphatic glands (except mutton and lamb).

324.80 IRELAND

A. Casings

1. Containers of animal casings consigned to Ireland shall be marked with the regular export stamp (Form MI-412-10). Each exportation shall be covered by Form MI-415-5.

324.83 ITALY

A. Meat Products

1. Export certificate to be visaed by consul of that country. Meat and meat food products will not be allowed into Italy unless a certification to the effect that the animals from which the meat was derived was never fed estrogens. This statement may be given by the inspector only if a satisfactory method can be developed by the establishment for identifying and certifying product as obtained from animals that were never fed estrogens. The exporter assumes the risk of rejection at destination on all product he elects to ship without this certification.

*2. Oleo oil required to contain 5 percent of sesame oil. The export certificate accompanying the shipment shall bear the statement "oleo oil to which exactly 5 percent of sesame oil has been added."

324.86 JAMAICA

A. Meat Products

1. To the export certificate covering fresh, frozen, cured and/or smoked meat should be added the statement "The United States is free from Foot-and-Mouth Disease."

324.88 JAPAN

A. Meat Products

*1. The following information in a Department letterhead certificate should accompany the regular export certificate for shipments of other than canned meats:

- a. Name and address of exporter.
- b. Name and address of importer.
- c. Kind (species) of animal.
- d. Quantity and weight (gross and net) of product.
- e. Name of inspecting authority.
- f. Dates of slaughter.
- g. The meat or meat product herein described was derived from animals which received ante-mortem and post-mortem inspection and showed no evidence of communicable animal diseases.

324.91 KENYA

A. Meat Products

1. Issue regular certificate, Form MI-412-3.

B. Casings

1. Issue sanitary certificate, Form MI-415-5.

324.97 MALAYSIA

A. Meat Products

1. Carcasses, meat and meat food products intended for export to the Federation of Malaya must be accompanied by the following certification:

- a. A general veterinary certificate stating that the country was free from foot-and-mouth disease and rinderpest for six months immediately prior to the slaughter of the animals from which the products for export to the Federation were derived.
- b. A certificate stating that the meat or meat food products have been derived from animals subjected to ante-mortem and post-mortem examinations and have been found to be free from infectious and contagious disease and that the products for

export to the Federation are fit for human consumption and that every precaution has been taken to prevent contamination prior to export.

c. An import permit from the state veterinary officer permitting the importation of such product into Malaysia.

*d. In the case of pork or pork products, a further veterinary statement is required certifying that the country or district was free of swine fever (hog cholera) during the last six months. "District" has been interpreted to mean a state or county. This statement is not required for canned pork products or for lard.

324.101 MEXICO

A. Meat Products

1. Five copies of the export certificate are required. The fifth copy should be a photostat of the original.

324.105 NETHERLANDS

A. Meat Products

1. Form MI-412-9 to be issued in addition to regular export certificates (except rendered animal fats).

2. The following fresh or frozen products from animals slaughtered in the U.S.A. are eligible for entry.

a. Beef cuts, with or without bone, weighing at least 6½ pounds. Each cut is to be branded.

b. Beef tails and beef tenderloins of any weight. Each piece is to be branded.

c. Pork bellies, hams, shoulders and loins. Each piece to be branded.

d. Edible organs.

3. Trichinae treatment is required for all product containing pork, including pork livers, pork kidneys and hog casings. The entire or partial treatment may take place prior to export or in bonded storage at destination. One of the following trichinae certifications will be signed by the veterinary inspector on the reverse side of Form MI-412-9.

a. Full treatment prior to export.

(1) "The pork has been refrigerated continuously for a period of three weeks at a maximum temperature of minus

15° C. (5° F.)"

(2) "The meat product has been heated in such a manner that an internal temperature of at least 80° C. (176° F.) has been reached."

b. Partial treatment prior to export.

(1) A statement given for actual freezing time supervised, e.g. "The pork has been refrigerated continuously for a period of five days at a temperature of minus 15° C."

c. No treatment prior to export.

(1) "No Trichinae Certification."

B. Rendered Animal Fats

1. The following antioxidants may be added to rendered animal fats or to combinations of rendered animal fats and vegetable fats exported to The Netherlands: dodecylgallate, octylgallate, propylgallate. The permitted amount of these antioxidants may not exceed 0.01 percent when used either singly or in combination.

2. The antioxidants dodecylgallate and octylgallate are not among those listed in 318.7(b) of the Meat Inspection Regulations but may be used for export only as provided in 318.8 of the Regulations.

3. Regular export stamps (MI-412-10) and certificates (MI-412-3) will be used as well as a certificate in the following form which may be executed by the responsible veterinary inspector at the request of the exporter:

"The undersigned (name and title of the authorized veterinary officer in the country of origin), at , certifies: that the edible rendered fats packed in (description of packing), gross weight , net weight and marked as follows -- (name of product), forwarded from (place of dispatch) by (name and address of shipper) and destined for (name and address of consignee) forwarded by (manner of forwarding, name of ship when shipped), were derived from slaughtering animals of the type as defined in the (Dutch) Meat Inspection Act, which were subjected to ante-mortem and post-mortem inspection and were found to be entirely sound and fit for human consumption; that, insofar as it contains common salt, it only contains it in very small quantities; that, insofar as preservatives have been used, no other preservatives have been used than propylgallate and/or octylgallate and/or dodecylgallate, and that the total contents of these gallates do not amount to more than 0.01 percent; that it is free from all other substances foreign to animal fats and oils; that the composition is in conformity with the composition as may be expected in view of the mark stated; that the composition in no respect is in contravention of the purport of this certificate.

Given at _____, on _____.

(Signature)

Meat animals as defined in the Dutch Meat Inspection Act are: Horses, cattle, sheep, goats, and swine. If the rendered animal fats being exported are derived from horses, regular export stamps and certificates will not be used.

C. Casings

1. Forms MI-415-5 and 412-9 shall be issued for animal casings destined to the Netherlands.

324.109 NEW ZEALAND

A. Casings

*1. May be admitted at the ports of Auckland, Gisborne, Napier, New Plymouth, Wanganui, Wellington, Lyttleton, Timaru, Port Chalmers, Dunedin, or Bluff, when accompanied with a certificate in the following form duly executed by the exporter and Division inspector:

Form No. 1

I, (give name and status) of the (give name of premises), (where casings are produced or prepared) situated at or near (give name of town) in the country or district of (country), in the country or State of (State) do hereby solemnly and sincerely declare that the sausage casings more particularly described below to be shipped by _____ of _____, to _____ of _____.

a. Were derived from animals which received ante-mortem and post-mortem veterinary inspection at the time of slaughter;

b. Were found to be healthy and in every way suitable for human consumption;

c. Are sound, healthful, wholesome, and otherwise fit for human consumption;

d. Have not been treated with chemical preservatives or other foreign substances injurious to health;

e. Have been handled only in a sanitary manner; and

f. Were not exposed to contagion prior to exportation.

Description of Casings

Number and Description of Packages	Description of Casings	Brands and Marks

And, I make this solemn declaration conscientiously believing the same to be true, and by virtue of the provision of (state here under what statutory provisions the declaration is made) _____.

Signed _____"

Declared at _____, this _____ day of _____ 19 _____, before me.

Signed _____"

In any country outside the British Commonwealth the declaration is to be made before a British consul or vice consul, or before any other authorized person.

Form No. 2

Government veterinarian's certificate to accompany sausage casings to New Zealand:

"I, _____, a duly qualified veterinarian, now employed by the Government of _____, hereby certify that I have no reason to doubt the correctness of the above declaration in any particular. Dated at _____ this _____ day of _____ 19 _____.

Signed _____"
(Veterinary Officer in Charge -
Meat Inspection Program)

Accordingly, a certificate as a single document, including Form No. 1 and Form No. 2 as above specified, shall be furnished in duplicate fully executed by the exporter and Officer in Charge for each consignment of sausage casings of animal origin destined to New Zealand. The certificate forms shall be supplied by the exporter. The animals are to be slaughtered in official establishments and handled only in a sanitary manner. Inspectors will satisfy themselves of the origin casings and the sanitary handling thereof before issuing certificates. Furthermore, all such casings intended for exporting to New Zealand shall first be examined by inspectors and only those found fit for use as sausage containers in official establishments shall be certified. A copy of each certificate shall be placed in the Circuit file.

324.113 NORWAY

A. Meat Products

1. Certificates to be visaed by consul. Imports by license only.

B. Casings

*1. At the request of the exporter, the following certification may be given on letterhead stationery:

"I hereby certify that the animal casings herein described were derived from healthy animals (cattle, horses, swine, sheep, or goats) slaughtered in a slaughterhouse in this country and received ante-mortem and post-mortem veterinary inspection at the time of slaughter. The product is declared fit for human consumption. The casings are clean and sound and were prepared in a sanitary manner and do not contain other preservatives than common salt (NaCl) and no coloring or bleaching agent. The barrels were thoroughly cleaned before packing and disinfected externally before leaving the plant and have not been used for products harmful to meat.

<u>Tarmsort</u> (Kind of Casings)	<u>Antall Kolli</u> (No. of Packages)	<u>Vekt.</u> (Weight)
--------------------------------------	--	--------------------------

Veterinaerens Kontrollmarke pa Kolli (Veterinary Inspector's Marks on the Packages)

Avsender (Consignor)	Adresse (Address)
-------------------------	----------------------

Mottaker (Consignee)	Bestemmelsested (Destination)
-------------------------	----------------------------------

Fraktmerke
(Shipping Marks)

(Signature)
Kontrollveterinaer autorisert av.
(Veterinary Inspector authorized by)

Veterinaedirektoratet mads
Gaustad."

324.119 POLAND

A. Meat Products

1. Export certificate to be visaed by consul of that country.

*2. The following letterhead certificate signed by an official veterinarian should accompany the regular export certificate for shipment of pork:

a. Meat is derived from hogs slaughtered in an establishment under permanent veterinary supervision.

b. Meat is derived from animals which received veterinary ante-mortem and post-mortem inspection.

c. Meat is sound and fit for human consumption with no indication of hog cholera (Swine Fever) or other contagious animal disease.

d. There is no foot-and-mouth disease in the United States.

324.121 PORTUGAL

A. Meat and meat food products are subject on importation to laboratory testing by the Portugese government to assure freedom from contamination by organisms harmful to human and/or animal health. Special certification regarding freedom of organisms is not required on export and will not be given by the inspector.

324.125 ST. VINCENT ISLAND

A. Meat Products

1. Export certificate covering fresh, cured, or smoked products destined to St. Vincent Island may be modified by adding the statement, "The United States is free of foot-and-mouth disease."

324.127 SALVADOR

A. Meat Products

1. Export certificate must be visaed by consul of that country.

324.133 UNION OF SOUTH AFRICA

A. Casings

1. The statement "And were free from infectious diseases at time of slaughter" may be added to Form MI-415-5 for hog casings.

324.137 SWEDEN

A. Meat Products

1. Prohibition on pork products due to hog cholera. On this reverse of the export certificate, "The meat or product described in this certificate was packed in a sanitary manner and is fit for human consumption."

(Signed)

324.139 SWITZERLAND

A. Meat Products

1. Issue Form MI-412-5.

2. Pork and pork products exported to Switzerland will be subjected to trichinoscopic examination at destination. In addition, shipments must be certified by an official veterinarian as meeting the following conditions:

- a. The pigs were derived from a state participating in the Federal-State hog cholera eradication program.
- b. The pork is derived from pigs slaughtered in a permanently supervised slaughterhouse and were found to be healthy before and after slaughter.
- c. The pork is wholesome and does not contain any antiseptic whatever.
- d. The pork has been prepared, handled, and dispatched according to the prevailing sanitary regulation.

These statements may be placed on the reverse side of the sanitary certificate or submitted separately on Department letterhead stationery.

324.148 VENEZUELA

A. Meat Products

*1. The following certification in Spanish or English may be added to the reverse of the regular export certificate or on letterhead stationery at the request of the exporter for pork exported to Venezuela:

"I certify that the product shipped under the certificate has been processed by a method approved by the United States Department of Agriculture which method is adequate to destroy any possible live trichinae. I further certify that this product has been held in a freezer for a period of not less than 30 days at a temperature not in excess of 5° F.

"_____
Officer in Charge

"Yo certifico que el producto enviado y amperado por este certificado ha sido processado por metados aprobados por el Departamento de Agricultura de los Estados Unidos y que son adecuados para destruir cualquier trquina que pudiese existir. Asimismo certifico que este producto ha sido mantenido en un congelador durante un periodo no menor de 30 dias y a una temperatura no excediendo 5 grados Fahrenheit."

It will be satisfactory to provide a modified variation of the certificate to suit other methods of treating pork for trichinae providing an accurate Spanish translation can be provided.

PART 325 - TRANSPORTATION

325.1 This part deals with the interstate transportation of product derived from animals covered in the meat inspection laws and provides the methods whereby the movement of such product can be regulated.

325.2 The movement of nonfederally inspected sound and wholesome meat derived from cattle, sheep, swine, or goats from one point in a state to another point in the same state which in its course passes through another state is not considered a violation of the Federal Meat Inspection Law.

325.3 Any person who makes proper certification may ship interstate product which is U. S. Inspected and Passed and so marked provided it is sound, healthful, wholesome, and fit for human food and has not been further processed or reprocessed other than under the supervision of a Federal meat inspector.

325.4 Officers in Charge are responsible for checking records of interstate carriers in their Circuit and Subcircuit areas to determine that such carriers are complying with the requirements outlined in Part 325 of the Meat Inspection Regulations. . This includes records of railroads, truck lines, airlines, railway express agencies, and post offices.

Compliance and Evaluation officers and others traveling through areas where no Meat Inspection employees are ordinarily stationed should avail themselves of the opportunity to check records of post offices and other carriers for compliance with this requirement whenever it appears to be indicated.

Inspectors will also occasionally review the shipping papers used by official establishments under their supervision to determine that they are complying with all requirements outlined in Part 325 for certifying interstate shipments.

These reviews should be made at least once each year and a report of the findings in letter form forwarded to the Washington office of the Processed Meat Inspection Division, attention Staff Officer for Special Services.

325.5 The requirements of the Meat Inspection Regulations are published in the following manuals and bulletins for interstate carriers:

A. Parcel Post - Part 125.36 and 331.46 (subparagraph .461) of the Postal Manual.

B. Railway Express Agency, Inc. - General Circular No. 2-D of the Railway Express Agency.

C. Railroads - Freight Tariff No. 362-B and Supplement issued by L. E. Kipp, Agent.

Section 325.5

D. Trucks - American Trucking Associations, Inc., A.T.A. Bulletin Advisory Service, pp. 25-36.

E. Airlines - Official Air Cargo Tariff Circular 1A, Section 5, pp. 29-36.

325.6 The form of the shipper's certificate and applicable requirements of this section of the Regulations should be used in connection with the movement of federally inspected horse meat or horse meat food products by proper alteration and identification to show the term "horse" preceding the word "meat;" that is, "horse meat" or "horse meat food products."

325.7 Product that is U. S. Inspected and Passed and so marked when shipped from an official establishment and conveyed interstate by vehicles belonging to the establishment need not be covered by certification outlined in Section 325.5 of the Regulations. This same ruling applies to federally inspected and marked product transported interstate by individuals in their own vehicles.

325.8 Meat Inspection Regulations provide for the application of official seals in certain circumstances to vehicles carrying unmarked or restricted meat or meat food products. The Federal Meat Inspection Law prohibits the breaking of such seals without proper authority. Such seals are sometimes broken unlawfully at destination as a result of improper loading at the origin establishment.

Such problems can be eliminated to a large extent if both shippers and inspectors assure themselves that the truck is properly loaded before the seals are applied. This assurance can result from examination of bills of lading, loading schedules, or other available information. Meat inspectors will not apply official seals until they have established to their satisfaction that the first scheduled stop for any vehicle bearing a mixed load is an official establishment. When sealed vehicles are diverted enroute, arrangements for breaking seals at the new destination should be made by the originating establishment.

325.9 Provision is made for the shipment under Meat Inspection seal from one official establishment to another of product which carries certain restrictions or which necessitates further processing or special handling.

An acceptable method of sealing fiber containers of restricted products consists of using a filament-type pressure-sensitive tape of a kind that will actually remove a part of the surface of the container whether removal is by intent or by accident.

A nonfilament-type tape that would have the same adhesive properties would also be acceptable. In using the tape method of sealing, the tape is firmly applied completely around the container in two directions and at the intersection of the two strips of tape, an impression of the 2½-inch rubber brand

is placed. The ink used in applying this impression must be of a kind that will withstand handling and remain legible during shipment of the product. An appropriately modified Form MI-408-1, furnishing complete information, should be used to notify the Officer in Charge at destination. When the shipment consists of boxes bearing a retained tag, the tag number should be shown on the form. If the boxes do not bear a retained tag, each box in the shipment should be dated and serially numbered (starting with the number 1) and the date and box numbers should be shown on the form.

Present supplies of Brooks seals may be used until exhausted. The establishment should supply acceptable tape and ink when required.

325.10 Tank cars of inspected and passed rendered animal fat moving between official establishments shall be marked as outlined in Section 317.16 of the Regulations. This regulation now requires the sealing of tank cars and tank trucks carrying inspected and passed product from one official establishment to another.

325.11 Officers in Charge are directed to report by letter to the Washington office, after a reasonable waiting period, the nonarrival of sealed cars. Full information should be given regarding the kind of product, vehicle identification, and originating establishment with other pertinent facts, including a statement from the establishment concerning its knowledge of the transaction.

325.12 Form MI-408, Notice of Unmarked Meat Shipped Between Official Establishments Under Seal, should accompany shipments of product under seal between official establishments. The form need not contain a detailed description of the marked product. Since it is known that the unmarked product constitutes at least 25 percent of the lot moved under seal, the weight of the marked product should be entered and it should be described as "various" if that term is applicable. However, the unmarked product should be described in detail as should also restricted product such as "U. S. Passed for Cooking" or "pork product _____ degrees F. _____ day refrigeration" or "beef passed for refrigeration." The requirement that at least 25 percent of the lot be unmarked to move under seal would not apply to boneless beef, veal or mutton.

The Form MI-408 must be securely attached to the carrier intended. As a suggestion, the copy of Form MI-408 to accompany a railway tank car should first be placed in a paper envelope; then placed in a plastic envelope and securely stapled. A slit is then made in the plastic and the paper envelopes and the Form MI-408 is secured to the meat inspection seal. Many railway tank cars are equipped with vent bonnets which are adjacent to the dome. When present, the plastic envelope may be placed in an envelope addressed to the meat inspector at destination and placed with the shipping papers being carried by the driver. Upon arrival at destination, the Form MI-408 will be delivered to the meat inspector.

325.13 Meat food products not bearing the mark of Federal inspection, such as cured ham, bacon, lard, sausage and the like, as well as hamburger and

chip steaks, which are transported or offered for transportation in interstate commerce under a certificate of exemption may be disposed of only to consumers such as families, restaurants, hotels, clubs, and not to any person or firm for resale as such.

325.14 For shipment of meat or meat food products to be accepted by a common carrier for transportation in interstate commerce under the authority of a certificate of exemption, it must be covered by a shipper's certificate executed in duplicate in the form set out in Section 325.10 of the Regulations. Both the original and duplicate copy of the shipper's certificate must be delivered to the agent of the transportation company accepting the shipment. The Processed Meat Inspection Division does not provide these forms and if the carrier fails to do so, the holder of the certificate of exemption should furnish his own.

A. When meat or meat food products are transported in interstate commerce under authority of a certificate of exemption in the private conveyance of the holder thereof, he should execute and mail to the Processed Meat Inspection Division a shipper's certificate.

However, when deliveries are made by private conveyance during any one day in other states to several customers who are consumers, an individual shipper's certificate for deliveries to each such customer is not necessary. Only one shipper's certificate showing the kind and total amount of product for that day and listing the consignee as "various" is required. When fresh meat not bearing the mark of Federal meat inspection is transported interstate in the private conveyance of the exemption certificate holder to another retail meat dealer, a shipper's certificate for each such interstate movement should be executed and mailed to the Processed Meat Inspection Division. Shipper's certificates covering interstate transportation by private conveyance need not be mailed to C&MS no more than once a week.

B. On the shipper's certificate used by retail meat dealers holding a certificate of exemption, whole carcasses or quarters should be listed as such under "Fresh Meats." The weight of the carcasses or quarters should also be included in the box "Number of Pounds" under "Fresh Meats" and added to the number of pounds of fresh meats shipped as trimmings or cuts if the certificate covers both carcasses and quarters, and fresh meats other than carcasses and quarters.

In reporting processed meats such as chopped, cooked, cured, dried, or canned meat, sausage or lard, it is not necessary to list each kind of product separately; they may all be grouped together and reported as one figure.

The number of nonfederally inspected carcasses that may be shipped interstate by a retail meat dealer holding a certificate of exemption is limited by the Meat Inspection Act. The number of carcasses and the fresh meat equivalents are as follows (per week):

	<u>Carcasses</u>	<u>Pounds</u>
Beef	5	3,000
Veal	25	1,875

	<u>Carcasses</u>	<u>Pounds</u>
Mutton	20	1,200
Lamb	25	1,250
Pork	10	2,000
Goat	20	1,000
Goat kids	25	500

C. It is urged that the correct form of shipper's certificate be used by retail butchers and retail dealers who are holders of certificates of exemption. It should be printed on a good grade of paper exactly 3½"x 8" in overall size. Certain entries that do not vary may be printed on the form; for instance, the shipper, his address, the exemption certificate number, and probably the point of shipment.

325.15 Identification of product derived from animals slaughtered by a farmer on the farm is acceptable if his name and address appear on the product by means of a brand, tag, label, or other appropriate means. The definition of a farmer appears in Section 21(a) of the Meat Inspection Act.

325.16 Meat and meat food products derived from cattle, sheep, swine, goats, or horses, that are to enter interstate or foreign commerce, must be U. S. Inspected and Passed and so marked; that is, fully prepared in an establishment operating under Federal meat inspection, unless the meat and meat food products are exempt from inspection. There are no exemptions from inspection provided by the Horse Meat Act, although the Meat Inspection Act provides for certain exemption for meat and meat food products derived from cattle, sheep, swine, and goats.

Therefore, nonfederally inspected meat and meat food products derived from cattle, sheep, swine, goats, or horses, that are not exempt from inspection must be treated (denatured) in a manner to alter their resemblance to an article of human food if moved interstate. This would apply to animal food composed in whole or in substantial part of material derived from cattle, sheep, swine, goats, or horses. The Processed Meat Inspection Division will give an opinion of the acceptability of the denaturing when furnished a sample.

However, animal food packed in hermetically sealed, retort processed, conventional retail-size (approximately one pound) containers and labeled conspicuously as, for example, "animal food," "dog food," "dog and cat food," is not required to be denatured. This means that the name of the product, such as "dog food," should appear on the main panels of the label in letters at least three times larger than the letters used in the words describing the materials derived from cattle, sheep, swine, goats, or horses, wherever the latter appear on the label, and with the background being equally as contrasting in the former as in the latter. In judging the 3 to 1 ratio, the height, width, and thickness of the letters are taken into consideration. If it is desired to use a label in lieu of denaturing the canned article, it is suggested that a sketch of the proposed label be sent to the Washington office. If accepted, the finished label can be printed. If the sketch is to be returned, two

copies should be furnished. The color scheme should be indicated.

Jurisdiction exercised by Federal meat inspection over labeling in lieu of denaturing in connection with canned animal food moving interstate comes from the applicability of the Federal Meat Inspection Act or the Federal Horse Meat Act and regulations promulgated thereunder. This does not override the authority of any other agency having jurisdiction in connection with the interstate movement of canned animal food. .

325.17 The various forms used in reporting transactions arising from the application of Section 325.13 of the Regulations will be handled at the Circuit when permits are issued for the return to an official establishment of alleged unsound meat or product that is in commercial channels. However, the original copy of the permit will be handled by the initial carrier as indicated in the Regulations and mailed to the Washington office. It is no longer necessary to use Form MI-409-2, as the disposition of the returned alleged unsound product can be noted in the Circuit copy of Form MI-409-1 without any report of its disposition being made to the Washington office.

Under the qualifications specified in 325.13(d) of the Regulations, alleged unsound products may be transported between official establishments. The return of product, found to require reconditioning prior to its use, must be approved by the Officers in Charge of the respective Circuits involved. The shipment must be made under official seal accompanied by Form MI-409-1, Permit to Return Alleged Unsound Product," describing the shipment and the reason for its return. Form MI-437, Notice of Receipt of Unclean or Unsound Product," must be completed and distributed in the usual manner for each return shipment between establishments. On its return to the official establishment, the inspector will notify his Officer in Charge who will make the necessary arrangements to have supervisory inspectors present for the reinspection of the returned product.

325.18 In the event it is necessary to denature nonfederally inspected rendered fat which resembles an edible product and which is offered for exportation, importation, or interstate movement, charcoal of vegetable origin of fine particle size may be used as a denaturant in the proportion of one pound of such charcoal to 10,000 pounds of rendered fat.

The following denaturants may be used, but might not be acceptable to the shipper because of certain objectionable properties which would make the rendered fat unacceptable for the intended use.

To each 750 pounds of fat, use:

One-third ounce of brucine dissolved in a mixture of two parts of alcohol (ethyl, methol, isopropyl, or denatured) and four parts of pine oil or oil of rosemary. (The amount of alcohol and pine oil or oil of rosemary is not specified as it is only required that enough be used to dissolve the one-third ounce of brucine.)

One-half gallon creosote.

Two gallons of pine tar.

One-fourth gallon of pyridine.

One-half gallon of No. 2 fuel oil or approved mineral oil.

When the laws or regulations of a foreign country to which such fats are being exported require or permit the use of other denaturants, such alternate denaturants may be used providing they properly accomplish decharacterization.

It is the shipper's responsibility to see that the article is acceptably denatured.

PART 326 -- FEDERAL FOOD, DRUG, AND COSMETIC ACT

326.1 Procedure of action taken by the Food and Drug Administration against interstate movement of meats and meat food products found to be in violation of the Food and Drug law is as follows:

Section 902(b) of The Food, Drug, and Cosmetic Act exempts meats and meat food products from its provision to the extent of the application of the Meat Inspection Act. Since the Meat Inspection Act contains no seizure provisions, meat and meat food products that are violative of the Food, Drug, and Cosmetic Act are not exempt from seizure under this Act. The Meat Inspection Program has welcomed in the past and will continue to welcome seizure actions by the Food and Drug Administration against violative meat food products found in interstate channels, in the interest of the protection of the public.

If a Meat Inspection Program inspector anywhere in the field encounters a consignment of a meat product that is unsound or unwholesome, he has no authority to institute action against it but he has the following responsibilities:

A. If he is stationed in a location near a Food and Drug inspector, he should notify the Food and Drug of the violation and request them to retain the product pending action under C below.

B. If no Food and Drug Administration inspector is in the vicinity, he would request an appropriate state or municipal official to initiate a similar action.

C. He should notify the owner of the violative product that action has been initiated, and that he may at his option rework the product under the Meat Inspection Program supervision to remove the cause of the violation.

1. If the owner agrees to reclean the product, the inspector (through his District Director) should arrange for release of the product and shipment under proper security to the establishment where the work is to be done.

2. If the owner refuses to reclean the product, so inform the Food and Drug Administration or state officials, and request they take whatever additional action they may desire.

If the violative shipment is discovered by Food and Drug Administration officials, they can proceed against the product under the Food and Drug law. Notification of the action should be given to the nearest Meat Inspection Program office, and an attempt made to proceed as in Paragraph C of this section.

PART 327 - IMPORTED PRODUCTS

327.1 Part 329 of the Meat Inspection Regulations has been extended to cover the importation of horse meat and horse meat food products. Approved foreign horse meat inspection certificates are shown in Part 329 of this Manual.

327.2 Meat and meat food products derived from ruminants or swine imported from countries in which diseases of rinderpest, foot-and-mouth, or African Swine Fever exist are subject to restrictions imposed by Animal Health Division. Vessels carrying fresh or frozen meats from non-infected countries may transit infected countries if the ships' compartments or holds containing the meat are officially sealed. Animal Health Division or Plant Quarantine Division personnel will determine whether these requirements have been satisfied before the meat is landed. When the shipment is in order, the customs entry forms will be stamped "Released by ARS Inspector." Shipments are not to be inspected for entry until the above procedure has been followed and we are assured that the meat is eligible under the Quarantine Regulations for importation.

327.3 A foreign meat inspection certificate which is approved and published in this Manual may be accepted regardless of whose signature appears thereon. If a foreign meat inspection certificate is only in the form prescribed in Section 327.6 of the Regulations, it must be signed by an official authorized by the national government of the foreign country in which the product was prepared and whose name and signature have been officially published in this Manual.

327.4

A. Certification required for canned corned beef containing head meat, cheek meat and/or heart meat is outlined in Part 327.6(i) of the Regulations. No product containing head meat, cheek meat, heart meat and/or other viscera products from Argentina, Brazil, Costa Rica, Guatemala, Honduras, Nicaragua, Paraguay and Uruguay shall be allowed entry except from specified establishments listed in the "Foreign Establishment List" of the current Working Reference.

B. Certification in addition to the foreign meat inspection certificate is required for all comminuted meat products such as luncheon meats and chopped ham imported from Denmark and the Netherlands. This certification will be required on the reverse side of the foreign meat inspection certificate and should be signed by the same inspector signing the face of the certificate. It will read as follows:

"I hereby certify that the product described on the reverse side of this certificate was prepared under the continuous supervision of an inspector of

the Ministry of Agriculture and that the formula, method of preparation and container used to manufacture and package this product conform to those approved by the United States Department of Agriculture for this product. I further certify that the product conforms to the ingredient statement on the label and to the applicable parts of the Regulations Governing the Meat Inspection of the United States Department of Agriculture."

Comminuted product not accompanied by this additional certification will be refused entry into the United States.

327.5 Since canned product is heated to a temperature sufficient to destroy trichinae, no purpose would be served by requiring a certificate, as required in Section 327.6(f) of the Regulations for canned product containing pork.

327.6 Occasionally, a consignment of canned meat or meat food product covered by one foreign official meat inspection certificate will be separated into several lots. These lots will be unloaded at various ports. Usually such shipments consist of canned product from South American countries. For the handling to be uniform, the Circuit that received original official foreign meat inspection certificate covering the entire consignment will request the broker to furnish sufficient copies (photostat) so there will be one for each Circuit where one of the lots is destined. The initial Circuit will authenticate each of those certificate copies, placing on it the name of the Circuit to which each lot is destined and the number of cases of product that will be marked to indicate the same information. If there is not sufficient space on the original certificate for this information, it should be placed on a separate sheet and securely affixed to the certificate.

327.7 Officers in Charge receive requests to inspect imports at other than official establishments. They are authorized to make these inspections in compliance with Section 327.8 of the Regulations. This applies whether the product is within reasonable geographic limits of the Circuit or located geographically so that the import inspection might have logically been handled by another Circuit. In the latter case, the availability of an inspector must necessarily be considered. If the workload at a small circuit is such that it requires the constant attention of the personnel assigned so that the request cannot be honored, then the person requesting the service should be so informed and asked to submit his request to the Officer in Charge of a larger Circuit near where the product is, or to the District office. The party requesting the inspection service is to reimburse the meat inspection appropriation for the expense of travel, subsistence and any overtime that an inspector incurs away from his official Circuit. No charge is made for the base time of the inspector.

327.8 This section provides procedures for the inspection and reinspection of condition of containers for imported canned product.

Sampling Rules. A random sample is a group of units selected from a lot in an unbiased manner that gives every unit an equal chance of being included in the sample.

A proportional random sample. A sample in which the number of units selected from each code, mark or other separately identifiable portion of the lot is proportionate to the approximate number of units in each code, mark or portion. This kind of sample is drawn whenever the make up of the lot is known.

A simple random sample. A sample in which the units are selected at random throughout the lot without regard to representation of any portion. This kind of sample is drawn whenever units are similarly identified by code, mark or location; or whenever the number of units in separately identifiable portions is very small or not known.

Each random sample must be as representative of the lot as possible. Use predetermined random sampling patterns to preclude bias in deciding which units to select. Do not exclude obviously defective units, since all units included in an offered lot must be eligible for selection in the sample. The inspector shall:

A. Determine the lot size in terms of individual cans. Importers should be encouraged to group as one lot, all small lots of same can size, type and style; filled and similarly processed by one establishment.

B. Use normal, tightened, or reduce sampling plan as specified by Processed Meat Inspection Division. (Information regarding the plan specified as in Table 1, 3, or 4.);

C. Randomly select enough shipping containers to yield the correct number of cans for the sample. Cans are randomly selected from the shipping containers in accordance with the following schedule.

<u>If No. of cans in carton is:</u>	<u>No. of cans to select is:</u>
5 or less	All
6 - 12	6
13 - 60	12
61 - 250	16
251 or more	24

D. Draw more cans from each carton if the number of shipping containers in the lot is not sufficient to yield a full sample in accordance with the above schedule.

E. Select all cans in the lot if the total number of cans in the lot is less than the required sample size.

Inspection. Procedure requires the inspector to: Examine each can in the sample; classify all defects found in accordance with the "Guide for Classifying Can Defects" below; record on the Form MI-460; and total the critical defects, major defects and total defects found.

Guide for Classifying Defects

<u>TYPE OF DEFECT</u>	<u>CLASSIFICATION</u>
Blown can or hard swell (can that is severely distended or ruptured because of internal gas formation).	Critical
Flipper or springer (can with one end that is convex or that will distend with pressure on the side or other end of can).	Critical
Loose tin or short vacuum (can ends will be bulged or the can will have loose side tin).	Critical
Overstuffed can (can ends will bulge due to excessive fill).	Critical
Mechanically punctured can.	Major
Can with one or more major dents affecting a seam or key opening scoring.	Major
Can with improper end or side seam.	Major
Can with one or more buckles affecting an end seam or key opening scoring.	Major
Can with one or more cable cuts exposing internal laminations of the end seam.	Major
Can with areas of baseplate pitted by rust.	Major
Can with missing or partially illegible label.	Major

Determining Lot Acceptance or Rejection.

On lots where a full sample is obtained, the inspector shall: Compare the number of critical defects found with the acceptance (Ac) and rejection (Re) numbers shown for the applicable sampling plan in Table 1, 3, or 4. Compare the total number of defects (major and critical) found with the Ac and Re numbers shown for the applicable sampling plan in Table 1, 3, or 4; accept the lot if the number of critical defects and the number of total defects are each equal to or less than the Ac criteria for the plan; reject the lot if either the number of critical defects or the number of total defects found, equal or exceed the Re number for the plan.

On lots where the indicated sample size exceeds the lot size, the inspector shall: Inspect all cans in the lot; eliminate all defects; accept the remainder of the lot for entry, providing that no more than one critical defect was found.

CONDITION OF CONTAINER SAMPLING PLANS

TABLE 1

Sampling Plans for Normal Inspection

Lot Size (cans)	Plan No.	Sample Size (cans)	Critical Defects Total Critical & Major Defects			
			Ac	Re	Ac	Re
6,000 or less	N2	84	0	1	4	5
6,001 - 12,000	N3	168	1	2	7	8
12,001 - 36,000	N4	315	2	3	13	14
36,001 and over	N5	500	3	4	18	19
	N6*	800	4	5	27	28

*Optional sample size for especially large or suspicious lots.

Determining Acceptability of a Rejected Lot for Sorting.

If a request is received for sorting of a rejected lot, the inspector will determine its eligibility for sorting by comparing the number of defects found in the rejected lot with the criteria listed in Table 2, and if the number of defects found exceeds the applicable limits in any category, sorting is not permitted and the product is refused entry. If the number of defects equals or is less than the applicable limits in all categories, the lot may be sorted and reoffered for inspection under the following conditions: There is no evidence that the product was improperly prepared, improperly certified at origin, or is otherwise unsound; the sorting and removal of defective cans must be done by competent people under the general supervision of the inspector; all unsound cans must be removed from the lot and be re-exported or destroyed.

TABLE 2

Limits for Determining Acceptability of a Rejected Lot for Sorting

Plan No.	Sample Size (cans)	Blown Cans, Hard Swells	Total Critical Defects	Major Defects
1	29	1	3	No Limit
2	84	1	7	No Limit
3	168	2	11	No Limit
4	315	3	19	No Limit
5	500	5	28	No Limit
6	800	7	42	No Limit

Determining Acceptance or Rejection of Sorted Lots. The inspector shall follow the procedures previously outlined for the sampling, inspection, and acceptance or rejection of the sorted lot, except he shall use the sampling plans and Ac and Re criteria shown in Table 3, Tightened Inspection (sorted lots).

TABLE 3

Sampling Plans for Tightened Inspection

Lot Size	Plan No.	Sample Size (cans)	Critical Defects		Total Critical & Major Defects	
			Ac	Re	Ac	Re
6,000 or less	T3	168	0	1	5	6
6,001 - 12,000	T4	315	1	2	8	9
12,001 - 36,000	T5	500	2	3	12	13
36,001 and over	T6	800	3	4	18	19

TABLE 4

Sampling Plans for Reduced Inspection

Lot Size	Plan No.	Sample Size (cans)	Critical Defects		Total Critical & Major Defects	
			Ac	Re	Ac	Re
6,000 or less	R1	29	1	2	2	3
6,001- 36,000	R2	84	1	2	4	5
36,001 and over	R3	168	1	2	7	8

The inspector shall complete Form MI-460 and make disposition in accordance with instructions on the form.

Officers in Charge may permit the release of these shipments following the routine import inspection but prior to the completion of incubation of the sample providing previous shipments or similar product (same brand and/or manufacturer in the foreign country) have been found to be consistently satisfactory. The number of satisfactory previous shipments should be sufficient to satisfy the Officer in Charge that the manufacturer is following competent canning and processing practices. If, however, incubation indicates a serious unsound condition, redelivery of the lots should be requested and subsequent lots held pending incubation.

327.9 There appears in the Working Reference a list of foreign meat establishments by number, name and location. The establishments are listed in numerical order under the names of the foreign countries (in alphabetical order) whose meat inspection system we consider comparable to ours. Countries have been informed that the identifying number and name of the producing establishment must appear on the approved foreign meat inspection certificate covering shipments.

Product will be inspected at entry points from only those establishments that appear on the published listing. Import inspectors will check the origin of shipments before making inspection of products.

327.10 All imported product shall be inspected at the port or destination with applicable instructions regardless of country of origin. Such product shall have approved certificate of the foreign country covering the shipment.

If the shipment has been diverted from its original inspection point, the inspector at the Circuit where the product is presented will not inspect until the importer or shipper arranges for him to contact the Circuit where the first three copies of the Form MI-410 were sent. This can be done by telephone at the importer's expense if he wishes to expedite the inspection. After the inspector has arranged to have the copies of the form forwarded to him, he can proceed with the inspection.

If the fourth copy of Form MI-410 is received at a Circuit and the import shipment does not arrive within two weeks and there is no other information that the shipment has been diverted, then the inspector will notify the Director of Customs at the port of entry of the nonarrival of the shipment and request that redelivery of the shipment be demanded by Customs under the redelivery bond.

327.11 Facilities required for import inspection should include the following:

- A. Freedom from dust, flies and insects.

- B. Sanitary rust-resisting metal tables, preferably of stainless steel.
- C. Adequate lighting with a minimum intensity of 50 foot candles.
- D. Ample supply of water for cleaning and hand washing.

327.12 Facilities for defrosting and inspection of the thawed samples must be provided by the importer in convenient locations. These facilities should include the requirements of 327.11. In addition, defrosting rooms must be adequately drained and hot and cold water must be available in the immediate area for cleaning and hand washing.

327.13 In the dockside inspection of frozen (tempered) meats, washrooms should be available to the inspectors and service contractors within reasonable distance. A minimum of three men should be assigned to each import inspector for the handling of the samples. One of these men should be designated to remove the meat wrappers after the boxes have been opened. He should not be permitted to handle the shipping containers at any time.

327.14 Product may be stamped before the completion of inspection only if the lot is to remain in storage in the immediate area. Under the circumstances, it is to be available for the removal of the inspection stamps if the shipment is rejected. We cannot allow stamping until after inspection if the product is to be delivered to the consignee or shipped to destination.

327.15 Primal or retail cuts of meat, either boneless or bone-in individually wrapped in a manner that permits separation of the pieces, may usually be satisfactorily inspected in the frozen state by tempering to remove surface frost. Imported edible organs and such products as tongues, tails, cheek meat and head meat should be routinely defrosted.

327.16 A Circuit history of all imported processed products must be maintained. The record of each entry should include establishment of origin, name of product, the amount of product, date of entry, results of inspection, and the disposition of the shipment.

The history is to be used to determine factors such as the necessity for laboratory samples, necessity for holding shipments pending laboratory findings, necessity for holding shipments pending completion of incubation, and deciding disposition of shipments in doubtful cases. Product history may be communicated from one Circuit to another at the request of an importer.

Instructions for laboratory sampling for specie identification will be directed by Processed Meat Inspection Division as outlined in 318.8C of the Manual.

Shipments of boneless meats which arouse suspicion because of the character of the product, condition of container, or lack of proper identification should be sampled for specie determination at all times. Samples of ground meats may be submitted if there is suspicion that they were prepared at unusual hours of operations.

327.17 Data, based upon the experience at your Circuit, should be submitted to the Processed Meat Inspection Division in the event you recommend a change in the handling of any particular product.

327.18 Sample size for opened can product examination of imported comminuted type product:

<u>Lot Size</u>	<u>Sample Size</u>
Less than 2000 cans	One percent of the consumer-size cans in the shipment or one institutional-size can.
2000 to 50,000 cans	Twenty cans of 1-pound net weight or less; for institutional-size cans open 20 pounds net weight of the product to the closest unit; e.g., two 10-pound cans, three 6-pound cans, four 5-pound cans, etc.

Larger consignments should be divided into two or more lots and sampled proportionately on the above basis.

Sample size for product examination of canned hams, canned picnics, canned pork loins, and other canned imported items which consist primarily of a solid, single piece of meat:

<u>Lot Size</u>	<u>Sample Size</u>
1 - 2000 cans	One can
2000 - 4000 cans	Two cans
4000 - 6000 cans	Three cans

The number of cans opened in large entries should be in the same proportion; i.e., one can for each 2000 cans in the consignment.

327.19 Concurrently, with the examination of the product, a sufficient number of the opened cans should be washed, dried and weighed to determine the average tare weight. The instructions in Part 317 of the Manual should be followed in this regard. In most cases, a minimum of 50 unopened cans should be weighed to determine the accuracy of the net weight statement.

When cans weighing more than one pound are examined and the tolerance allowed in Section 317 of the Manual is slightly exceeded, one additional can for each 1000 cans in the shipment may be opened and weighed. The average net weight should equal the stated net weight. Thus, in a shipment of 3000 cans, two cans would be initially opened for product examination. If additional samples are indicated due to short weight, three more cans may be opened and weighed. Acceptance or rejection of the lot would then be based on the average net weight of the five cans. Paragraph 327.8(n) and (q) of the Regula-

tions, as well as the instructions in this Manual, regarding the incubation of sterile canned products containing pork remain unchanged.

327.20 Control of Added Substances in Imported Canned Hams, Picnics and Loins - The formula for estimating yield and the protein multipliers are the same as for domestic canned hams, picnics and loins. Zones for control purposes into which laboratory results for added substance should fall:

	<u>Canned Hams, Loins</u>	<u>Canned Picnics</u>
Upper Control Limit	116.3 and above	113.6 and above
Zone A	113.6 to 116.2	111.7 to 113.5
Zone B	110.2 to 113.5	109.9 to 111.6
Zone C	108.1 to 110.8	108.1 to 109.8

Inspection action related to laboratory results which the inspector should follow.

A. Not release product without a history until three consecutive lots have been found satisfactory by laboratory analysis.

B. Release product without awaiting laboratory results after requirements in A. have been met.

C. Hold the next lot of product pending satisfactory laboratory results when Zone B analysis of a released lot is obtained.

D. Hold the next two lots of product pending satisfactory laboratory results when Zone A or higher analysis of a related lot is obtained.

E. Use the following criteria in deciding an acceptability of analysis of held lots.

1. Zone C or lower, accept the lot.

2. Zone B

a. Refuse entry, or

b. Submit another sample, accepting if Zone C or lower, rejecting if in Zone B or higher.

3. Zone A

a. Refuse entry, or

b. Submit two additional samples, accepting if both samples are in Zone C or lower, rejecting if either is in Zone B or higher.

4. Upper Control Limit, refuse

F. Following a rejected shipment, hold product until three consecutive lots have been found satisfactory.

327.21 No major reconditioning, sorting, or rehandling will be permitted by the inspector unless authorized by the Processed Meat Inspection Division, except as outlined in Part 327.8 of the Manual.

In no case will permission be granted for reconditioning of product which has been refused entry for any condition that indicates the product was improperly prepared or certified in the country of origin.

327.22 Occasionally products are found to be seriously unacceptable after release by the Meat Inspection Program following the initial import inspection (for example, canned meat products might be found to be underprocessed). In these instances and after counsel with the Processed Meat Inspection Division, local Director of Customs may be asked to demand redelivery of the product if it has already been distributed.

327.23 Undercooked (less than 150°F.) perishable canned product cannot be allowed entry from foot-and-mouth disease infected countries under Animal Health Division regulations. These include all of the European countries presently exporting canned meats to the United States. The Meat Inspection Regulations also require perishable canned products to be processed to a minimum of 150°F. internal temperature. If underprocessing is confirmed, submit the laboratory report, Form MI-422-2, immediately to Processed Meat Inspection Division. Disposition of the shipment should be noted on the reverse side of the form. The following consignment of the same product is to be held until laboratory results are obtained.

327.24 When it is necessary to correspond with the Processed Meat Inspection Division concerning a particular consignment of imported product, it is important that full identification of the shipment be given in the opening paragraph of the letter. This should include:

- A. Number of cases, where canned product is involved, or weight of bulk shipment.
- B. Number and size of units in the container.
- C. Name of product, including brand name.
- D. Country of origin.
- E. Name of vessel or car number.
- F. Date of arrival.
- G. Customs entry number.
- H. Name and address of consignor.
- I. Name and address of consignee.

J. Any other pertinent identification.

For example: 2000 cases (48/12) blank brand canned corned beef, Product of Argentina, ex S. S. Rowboat, November 12, 1959, Customs Entry No. 2 consigned by blank blank and company, Buenos Aires, Argentina, to blank and company, 211 East First Street, New York.

327.25 Inspection of Imported Frozen Boneless Manufacturing Meats shall be performed in the same manner as outlined for Domestic Boneless Meats. The import inspector shall follow the procedures in Section 318.8 of the Manual. The MI-450 shall be completed in duplicate. File the copy with the MI-410 at the Circuit and forward the original to the MI Records Unit in Chicago, Illinois.

327.26 Foreign product presented for importation bearing grade markings the same as those used by the Meat Grading Branch, Livestock Division, Consumer and Marketing Service, United States Department of Agriculture, should not be passed for entry into this country until such time as the grade markings have been verified by a representative of the Meat Grading Branch.

327.27 The term "New Zealand Genuine Spring Lamb" may appear on carcasses of new-crop lambs slaughtered in New Zealand during the period beginning October 23 and extending to the following May 31. A signed typewritten certification to the dates of slaughter shall appear on the reverse of the official New Zealand meat inspection certificate accompanying the importation of lambs marked in this manner.

327.28 Imported lamb, other than carcasses with foreshanks attached, must be accompanied by an additional official statement on the foreign meat inspection certificate. The statement should identify the meat described on the certificate as derived from animals of the ovine species which were less than one year of age and on which the foreshanks broke at the distal epiphyseal cartilage of the metacarpal bone.

327.29 The markings of cartons of meat product offered for entry should be approved locally. Such designations as "bull beef," "cow beef," "fore-quarter beef," "hindquarter beef," etc., should not be permitted. The proper designation is "boneless beef" followed by the statement concerning the country of origin. We have no objection, however, to the use of code marks to distinguish the various trade categories of boneless beef. The code marks should have no labeling connotation.

327.30 The maximum quantity of ham, bacon, and fresh meat permitted entry for personal use of the consignee is 100 pounds; canned meats, sausage, and similar products other than summer sausage is 50 pounds; lard, 20 pounds; summer sausage, 20 pounds.

327.31 The instructions relative to personal consumption entries require that boneless cured or cooked meat from countries in which foot-and mouth disease or rinderpest exists must be entered and handled in the same manner.

as regular commercial importation in order to comply with Animal Health Division rulings.

327.32 The usual methods of handling rejected product are by re-exporting it under Customs custody or by destroying it by incineration or tanking under the supervision of a meat inspection employee. If the imported product has been refused because of soilage, contamination, or other reasons that would not preclude its use as an animal food (and such use would not be in conflict with Federal and State laws or regulations), it may be decharacterized by freely slashing the product and coating all surfaces with finely powdered charcoal; by coloring the product with a suitable dye solution; or by grinding the product with coarsely ground hard bone so that the resultant article would be effectively removed from a human food category.

When shipments are rejected on destination inspection, the Director of Customs at the original port of entry must be notified of this decision. He should be advised to supply evidence of re-exportation of the product. The Customs station having responsibility for the entry is identified in Block 1 of Section D of the Form MI-410. It is not, however, necessary to seal the shipment for return to the port of entry.

The rejected product must be handled in a manner that will limit our supervision to a minimum at the port or place of inspection. No charge is made for this type of supervision, since it is part of our normal import responsibilities to see that rejected meats are destroyed for human food purposes or re-exported under Customs custody.

If, however, the importer prefers to move the rejected product without decharacterization to an animal food manufacturer or canning plant where it will be used as an ingredient of animal food, such movement and additional supervision may be done by a meat inspection employee only on a reimbursable basis. The animal food manufacturer must apply for Animal Health Division "Certification of Inedible Animal Byproducts" service as outlined in Animal Health Division Memorandum No. 592.1. This arrangement provides for supervision of the rejected article until it is canned or labeled as animal food or otherwise decharacterized.

Shipment of rejected product between Circuits must be in sealed conveyances. Part 4 of MI-410 may be used to notify the Officer in Charge at destination. The completion of the disposition should be indicated on this copy which is then returned to the originating Circuit.

In some cases involving breach of Customs bond for failure to comply with meat inspection requirements in the importation of foreign meat or meat food product, local Directors of Customs are authorized to assess a money penalty less than the full liquidated damages after having come to an agreement with the local Officer in Charge of Meat Inspection. The Officer in Charge should not make any recommendations on the assessment in lieu of liquidation. He should communicate with the Processed Meat Inspection Division, through his District Office, giving full particulars involving the mishandling. He then will be advised concerning the penalty to be recommended.

327.33 Only one report on Form MI-410 shall be made for each entry. Otherwise, there is a possibility of duplication in records. If, however, it is necessary to send in a correction, the report should be conspicuously marked "Corrected Report" at the top of the form, and the date of the MI-410 report that it supersedes. It is important to Processed Meat Inspection Division to receive immediate information on the origin of unsuitable imported product. As a means of obtaining this information, a copy or facsimile of the import certificate should be forwarded to the Staff Officer for Export-Import whenever a consignment is refused entry.

The certificate need not be sent in where rejections are made because of damage in handling or in instances where the product does not exceed allowable tolerances and is passed for entry. It is, however, necessary that we have this information when substantial quantities of a shipment are refused entry.

In addition to the data supplied by the foreign government, the following information should be typed or legibly handwritten on the certificates:

- A. Place (Circuit) and date of inspection.
- B. Customs entry number.
- C. Foreign establishment or establishments of origin.
- D. Amount of product inspected.
- E. Cause of rejection.
- F. Total amount of product refused entry.

The details concerning the cause of rejection are necessary. A statement such as "contamination" should be amplified, for instance, to describe the type of contamination discovered. In lieu of this, a copy of Form MI-450 should be attached to the certificate for rejected manufacturing meats.

In the event of rejection of an entire lot of imported product, the original foreign meat inspection certificate may be returned to the importer. A notation, signed by the Officer in Charge, should be made on the face of the certificate that the product was refused entry into the United States. It is not necessary to state the cause of rejection.

When imported product is rejected, the MI-410 may be distributed as soon as the importer or his agent indicates that the shipment will be re-exported. The re-exportation then becomes the responsibility of the Director of Customs. The MI-410 should, however, be held if product is to be denatured, or diverted to animal feed under our supervision. In such instances, the control of the rejected product is the Program's responsibility. Under these circumstances, the MI-410 should be distributed after disposition has been completed.

327.34 Form MI-410, Import Meat and Meat Food Products Report should be used to report all import inspections. Importers or their agents may obtain copies of this form from the nearest Meat Inspection office or Customs station.

A. The form should be completed as follows:

1. Port of Entry Inspection.-- Sections A, B, and C are to be completed by the importer or person acting as his agent.

2. Section B is to be completed with Section A but only when product is to be inspected at a location other than its present location such as from docks to warehouse. Product cannot be transferred to a location outside the limits of the Meat Inspection Circuit.

3. Destination Inspection.-- Section D is to be completed by the importer or person acting as his agent. (Used principally at Canadian and Mexican ports of entry).

4. Section E-- Disposition.-- This section and the block "Circuit Name and Number" at upper right-hand corner are to be completed by the meat inspector who made the inspection.

B. This form should be complete to Section E when it is received by the meat inspector who is to examine the product. The meat inspector is to do the following:

1. Write in the Circuit name and code number and the country code after the name of the country of origin.

2. Check the accuracy of all entries and make necessary corrections.

3. Initial each item that passed.

4. If the entire amount was refused entry or condemned, do not initial amount but enter in Section E the number of pieces or packages and weight of the product rejected, with cause, cause code, and disposition.

5. If part of the product passed and the remainder was refused entry and/or condemned, initial the shipment as usual but enter in Section E the number of pieces or packages and weight of that part which was rejected, the cause, cause code, and disposition.

6. See that disposition shows either refused entry or method of destruction for food purposes.

7. Where product is refused entry or condemned, code the cause of rejection. If there is more than one cause only the principal one should be coded.

Example of items 5 and 6: An import of 2,500 cases of canned corned beef weighing 45,000 pounds with a total of 3 cans rejected, 2 cans (1-1/2 pounds total weight) rejected for puncture and 1 rejected for swelling (3/4 pounds), should be reported in this manner: In Section C, on the line "Canned Meats Beef" (line 11, code 21), will be entered 2,500 cases, 45,000 pounds. In Section E, "Disposition," the inspector initials the entry since part of shipment passed; then he enters "2 cans 1-1/2 pounds puncture (49)" 1 and "1 can-3/4 pound sweller (58) incinerated" in the Cause and Disposition section.

In Section C no space is provided for write-in products because there should not be any. If the importer makes a write-in entry, the meat inspector should enter the item in its proper place. Following are two lists of products which should give an idea of products to be included under Canned Other and General Miscellaneous:

Canned Other

Goulash	Beef Extract (if canned)
Ham Spread and Cheese	Pate
Luncheon Meat	Pate de foie
Meat Balls	Liver Paste
Meat Spreads	Stews
Meat Samples	Sausage (if canned)
Corned Mutton	

General Miscellaneous

Edible Bones	Blood Pudding
Chitterlings	Rinds
Beef Extract	Spleens
Goat Meat	Sweetbreads
Cooked or Cured Mutton	Tripe
Pigskins	Edible Fats & Oils

Code for Countries of Origin

Argentina-----02	Ireland (Eire)-----30
Australia-----04	Italy-----32
Austria-----05	Japan-----21
Belgium-----06	Luxemburg-----31
Brazil-----08	Mexico-----34
Canada-----10	Netherlands (Holland)-----26
Costa Rica-----12	New Zealand-----38
Czechoslovakia-----16	Nicaragua-----35
Denmark-----18	Northern Ireland-----37
Dominican Republic--20	Norway-----36
England and Wales---22	Panama-----39
Finland-----23	Paraguay-----40
France-----24	Poland-----42
Germany-----25	Scotland-----41
Guatemala-----29	Spain-----43

Haiti-----	33	Sweden-----	44
Holland (Nether-		Switzerland-----	46
lands)-----	26	Uruguay-----	48
Honduras-----	27	Venezuela-----	49
Iceland-----	28	Yugoslavia-----	52

Code for Refused Entry or Condemnation

Artificially Colored-----	01	Nail Hole or Puncture-----	49
Bruises-----	03	Not Properly Labeled-----	50
Contaminated-----	05	Not Thoroughly Cooked-----	19
Crushed-----	41	Not Thoroughly Dried-----	21
Cut Can-----	40	Overstuffed-----	52
Damaged-----	07	Parasitic Infection-----	23
Dirty-----	09	Putrid-----	25
Discolored-----	11	Rancid-----	27
Excess Nitrite-----	13	Short Vacuum-----	54
Excess Water-----	42	Smeary-----	29
Flippers-----	44	Suspicious-----	56
Leakers-----	46	Swellers-----	58
Loose Tin-----	48	Tainted-----	60
Moldy-----	15	Unsound-----	62
Musty Odor-----	17	Miscellaneous-----	99

C. Copies of Form MI-410 should be distributed as follows:

1. Port of Entry Inspection:

Part 6 to Customs Office.

Part 5 to Customs Office on dock. (Parts 5 and 6 are used only when a temporary transfer is to be made. Distribution is to be made by applicant after being signed by both Meat Inspector and Customs Officer).

Part 1 to 4 to Meat Inspector making inspection who will make the following distribution:

Part 4 to the applicant.

Part 3 to Customs Office for release of bond.

Part 2 to Meat Inspection Office, Chicago, Illinois, with foreign import certificate. Part 1 is Circuit copy.

2. Destination Inspection:

Part 6 remains at the port of entry.

Part 5 to Director of Processed Meat Inspection Division,
U. S. Department of Agriculture, Washington, D. C. 20250

Part 4 to point of inspection with shipment.

Parts 1, 2, and 3 mailed to point of inspection by whoever signs Section D. Meat Inspector who makes inspection will make the following distribution.

Part 3 to Director of Customs at point of entry for release of bond.

Part 2 to Meat Inspection Office, Chicago, Illinois, with foreign import certificate. Part 1 is Circuit copy.

327.35

A. The form and substance of the meat inspection certificates of the following foreign countries have been approved as conforming to requirements of Sections 327.6(e) and (f) of the Meat Inspection Regulations. Such certificates are acceptable to cover importations of meat and meat food products from these countries regardless of whose signature appears on the certificates. Unless otherwise indicated, the certificates comply with Section 327.6(e):

Argentina	Iceland
Australia	Ireland (Eire)
Austria	Italy
Belgium	Japan
Brazil	Mexico
Canada	Netherlands
Costa Rica	New Zealand
Czechoslovakia	Nicaragua
Denmark	Northern Ireland
Dominican Republic	Norway
England and Wales	Panama
Finland	Paraguay
France	Poland
Germany	Scotland
(Federal Republic)	Spain
Guatemala	Sweden
Haiti	Uruguay
Honduras	Yugoslavia

The foreign meat inspection certificate should be forwarded to the Chicago office with Part 2 of completed Form MI-410.

B. Meat inspection certificates from Czechoslovakia should be authenticated by an American Consul or Vice Consul to be acceptable. The form of authentication is given below:

 SS: (venue)

I, (name of authenticating officer), (title), duly commissioned and qualified, do hereby certify that (name of officer) signing (name of country) meat inspection certificate, has been declared by competent (name of country) authorities to have been, at the time he signed the annexed certificate, (title of meat inspector), fully competent to sign and assume responsibility for such a certificate.

In Witness Whereof I have hereunto set my hand and affixed the seal of the (title of American mission) at (place) this _____ day of _____, 19____.

(Signature of officer)
(Official title of Officer)

* * * * *
* * * * *
* * * * *

Service No. _____
Item No. 38, no fee

C. The type of authentication to be used on official meat inspection certificates from Poland follows. It will be imprinted on the certificate by means of a rubber stamp.

PEOPLE'S REPUBLIC OF POLAND,)
CITY OF WARSAW,) SS:
EMBASSY OF THE UNITED STATES OF AMERICA)

I, the undersigned Consular Officer of the United States of America at Warsaw, Poland, duly commissioned and qualified, do hereby certify that the Polish Veterinary Official who signed the annexed certificate, has been declared by the competent Polish authorities to have been, at the time said official signed the certificate, fully competent to perform this act and assume responsibility therefor. IN WITNESS WHEREOF I have hereunto set my hand and affixed the seal of my office this day
.

.
Consul of the United States of
America

Seal
Service No.
Tariff Item No. 36
Gratis.

327.38 Facsimiles of approved foreign meat inspection certificates
follow:

ARGENTINA

REPUBLICA ARGENTINA



SECRETARIA DE ESTADO DE AGRICULTURA Y GANADERIA

DIRECCION GENERAL DE SANIDAD ANIMAL

EXPORTACION A LOS ESTADOS UNIDOS DE NORTE AMERICA

CERTIFICADO DE INSPECCION DE CARNES Y SUS DERIVADOS COMESTIBLES

(1)

CERTIFICADO

Nº

Se certifica por el presente, que la carne y derivados comestibles de la misma, detallados en este certificado, proceden de animales (*) que han sido sometidos a inspección sanitaria veterinaria nacional, antes, durante y después de faenadas y que dicha carne y derivados alimenticios han sido encontrados en perfectas condiciones higiénicas y buenas en absoluto para el consumo humano. Se certifica también que no contienen ni han sido tratados con ningún preservativo, materia colorante, ni otra substancia alguna prohibida por las reglamentaciones vigentes de la Inspección de Carnes del Ministerio de Agricultura de los Estados Unidos de Norte América.

MARCAS DE IDENTIFICACION EN LAS CARNES O LOS BULTOS

Remitente
Procedencia CERTIFICADO Nº
Vapor Destino
Consignatario
Marcas de embarque

DETALLE DEL CARGAMENTO

(2)

(3)

(1) Lugar y fecha en letras. (2) Firma del funcionario nacional autorizado.
(2) Especie de ganado. (3) Sello de la Dirección General de Sanidad Animal.



COMMONWEALTH OF AUSTRALIA

Exports (Meat) Regulations

DEPARTMENT OF PRIMARY INDUSTRY

I HEREBY CERTIFY that the undermentioned
shipped per

to on 19

has been examined and found, by ante-mortem and post-mortem veterinary inspection, to be free from disease and suitable in every way for human consumption, and that no injurious ingredient has been used in its preparation:—

Name of Exporter	Description of Meat	Markings	Number of Carcasses, Cases, Crates or Cartons

Dated at _____ in the State of _____
this _____ day of _____ 19____

Officer of the Department of Primary Industry

AUSTRIA



Bundesrepublik Österreich

Amtliches Fleischuntersuchungszertifikat für Schweinefleisch und Schweinefleischprodukte

(Für den Versand nach den USA von Waren, die Muskelgewebe des Schweines (enthalten) und im allgemeinen ohne vorheriges Kochen verzehrt werden.)

(Par. 27.6 (f) of the Meat Inspection Regulations of the United States.)

Ort: _____, Datum: _____
(Stadt) (Land)

Ich bescheinige, daß die Ware, die unten angeführt ist, im allgemeinen ohne vorheriges Kochen verzehrt wird und Muskelgewebe des Schweines enthält. Die Ware wurde in frischem oder in frischgepökeltem Zustande wenigstens zwanzig Tage lang einer Temperatur von höchstens 5° F ausgesetzt oder in Übereinstimmung mit einer Anweisung des Leiters der amerikanischen Fleischbeschauabteilung behandelt; diese Ware enthält keine Schweinemuskelgewebe, die nicht wie beschrieben behandelt wurden.

Art des Produktes:

Zahl der Stücke und Kolli:

Gewicht:

Identifizierungsmarkierungen
auf dem Fleisch und den Kolli:

Verfrächter:

Adresse:

Empfänger:

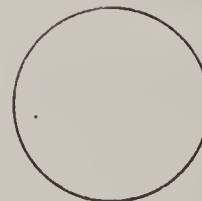
Bestimmungsort:

Versandmarkierungen:

(Unterschrift)

(Name des Beamten der österreichischen Regierung, der berechtigt ist, Untersuchungszertifikate auszuhändigen für Fleisch und Fleischprodukte, die für den Export nach den USA bestimmt sind.)

(Amtlicher Titel)



(Dienstsiegel des mit der
Überwachung beauf-
tragten Amtstierarztes)

Anmerkung: Obiges Zertifikat wird für jede Konsignation verlangt, die aus Produkten besteht, die gewöhnlich ohne vorheriges Kochen verzehrt werden (z. B. Cervelatwurst, italienischer oder westfälischer Schinken u. dgl.) und die Schweinemuskelgewebe enthalten. Dieses Zertifikat muß von dem Empfänger oder dessen Agenten der Fleischbeschauabteilung am Untersuchungsort in den USA übergeben werden.

BELGIUM

Kingdom



of Belgium

MINISTRY OF PUBLIC HEALTH

VETERINARY SERVICES

Official Meat Inspection Certificate

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine or goats which received ante-mortem and post-mortem veterinary inspection at the time of slaughter and that such meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with, and do not contain, any preservative, coloring matter, or other substance not permitted by the regulations of the United States Secretary of Agriculture governing meat inspection, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

Kind of product: Number of pieces and packages: Weight:

Identification marks on meats and packages :

Consignor :

Address :

Consignee :

Destination :

Shipping marks :



*Veterinary surgeon appointed
by the Government*

(s.)

Kingdom



of Belgium

MINISTRY OF PUBLIC HEALTH

VETERINARY SERVICES

Official Meat Inspection Certificate

for pork and pork products

I hereby certify that the article or articles herein described are of a kind prepared customarily to be eaten without cooking, and contain muscle tissue of pork which when fresh or freshly cured in salt, were subjected to a temperature not higher than 5° F. for not less than 20 days or otherwise treated as specified by the Chief of the Bureau of Animal Industry, and that said articles contain no muscle tissue of pork which has not been treated as herein specified.

Kind of product

Number of pieces and packages

Weight

Identification marks on meat and packages :

Consignor

Address

Consignee

Destination

Shipping marks



Veterinary surgeon appointed
by the Government

(s.)



CANADA
DEPARTMENT OF AGRICULTURE
HEALTH OF ANIMALS BRANCH
MEAT INSPECTION DIVISION

EXHIBIT NO. 1

SCHEDULE B, FORM 2

CERTIFICATE
COVERING
MEAT PRODUCTS

No. 696509

EST NO _____ PLACE _____ DATE _____

I CERTIFY THAT THE MEAT PRODUCTS HEREIN DESCRIBED ARE DERIVED FROM ANIMALS THAT RECEIVED ANTE MORTEM AND POST MORTEM VETERINARY INSPECTION AT THE TIME OF SLAUGHTER, AND THAT SAID MEAT PRODUCTS ARE SOUND, HEALTHFUL, WHOLESOME AND OTHERWISE FIT FOR HUMAN FOOD, HAVE NOT BEEN TREATED WITH AND DO NOT CONTAIN ANY PRESERVATIVE, COLOURING MATTER, OR OTHER SUBSTANCE NOT PERMITTED BY THE MEAT INSPECTION ACT AND REGULATIONS, AND HAVE BEEN HANDLED ONLY IN A SANITARY MANNER IN THIS COUNTRY.

KIND OF PRODUCT	NO. OF PIECES OR PACKAGES	NET WEIGHT

BRITISH
EXPORT
LABEL NO'S

FOREIGN
EXPORT
STAMP NO'S

CONSIGNOR
AND
ADDRESS

CONSIGNEE
AND
DESTINATION

SHIPPING MARKS
(NAME OF VESSEL OR
CAR NO. AND INITIALS)

SHIPPER

VETERINARY INSPECTOR UNDER MEAT INSPECTION ACT

IF SHIPMENT IS UNLOADED AND RELOADED WHILE IN TRANSIT, OTHER THAN A CHANGE IN MODE OF TRANSPORT, NOTIFICATION BY WIRE MUST BE SENT TO THE VETERINARY DIRECTOR GENERAL, OTTAWA, CANADA, AND THE FOLLOWING FILLED IN.

LOADED _____ AT _____
DATE PLACE

SIGNATURE OF OFFICER OR AGENT OR CARRIER MAKING INDORSEMENT

**PART 1: ATTACH TO EXPORT ENTRY FORM B13 TO BE FORWARDED
TO CUSTOMS OFFICER AT PORT OF EXIT FROM CANADA**

HA 32

Form 3

Schedule G

EXHIBIT NO. 2

CANADA
DEPARTMENT OF AGRICULTURE
HEALTH OF ANIMALS BRANCH

MEAT INSPECTION DIVISION

Place *Date*

Est. No.

Official Meat Inspection certificate for Pork and Pork Products, for shipment to the United States, of articles, or articles of a kind prepared customarily to be eaten without further cooking, which contain muscle tissues.

I hereby certify that the article or articles herein described are of a kind prepared to be eaten without further cooking, and contain muscle tissues of pork that when fresh, and freshly cured in salt, were subjected to a temperature not higher than 5°F. for not less than twenty days or otherwise treated as specified by the Director of the Meat Inspection Division, Consumer and Marketing Service, United States Department of Agriculture, and that said article contains no muscle or tissues of pork which has not been treated as herein specified.

KIND OF PRODUCT	No. of PIECES OR PACKAGES	NET WEIGHT

Identification Marks on Meats and Packages

Consignor Address

Consignee Destination

Shipping Marks (Name of vessels, railway or express)

Shipment supervised by
(Veterinary Inspector under the Meat Inspection Act)

PROPERTY
OF

CANADA
DEPT. OF AGRICULTURE
RR.

COSTA RICA



Nº 2051

Fórm. - MAC - 042 - 1961 - 5000

Perm. Exp. No. _____

REPUBLICA DE COSTA RICA

MINISTERIO DE AGRICULTURA Y GANADERIA

DIRECCION GENERAL DE AGRICULTURA Y GANADERIA

CERTIFICADO OFICIAL DE INSPECCION DE CARNES

Lugar
(Place)Fecha
(Date)

Se certifica por el presente, que la carne o producto comestible de carne aquí descrito, derivan de animales que recibieron inspección veterinaria ante-mortem y post-mortem al tiempo de sacrificarse; y que dicha carne y producto comestible de carne son buenos, sanos y apropiados para el consumo humano; y que no han sido tratados ni contienen ningún preservativo, sustancias colorantes u otras sustancias prohibidas por el Acuerdo de la Reglamentación para la Industrialización Sanitaria de la Carne; y que han sido manipulados en forma sanitaria en este país.

This is to certify that the meat or meat food products here in described were derived from animals which received ante-mortem and post-mortem veterinary inspection at the time of slaughter, and that said meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with and do not contain any preservative, coloring matter, or other substance not permitted by the Meat and Canned Foods Decrees and Regulations, and have been handled only in a sanitary manner in this country.

ARTICULOS (KIND OF PRODUCT)	NUMERO DE PIEZAS O BULTOS (NUMBER OF PIECES OR PACKAGES)	PESO (WEIGHT)

Marcas de Identificación de la Carne y Bultos
(Identification Marks on Meats and Packages)

Vapor
(Steamer S. S.)

Embarcador
(Consigner)

Dirección
(Address)

Consignatarios
(Consignee)

Destino
(Destination)

Marcas de Embarque
(Shipping Marks)

Médico Veterinario
Autorizado por el Ministerio de Agricultura y Ganadería
D. V. M. Authorized by the Secretary of Agriculture



ČESKOSLOVENSKÁ SOCIALISTICKÁ REPUBLIKA

ÚŘEDNÍ POTVRZENÍ O PROHLÍDCE MASA

Místo Československo Datum 19

Potvrzuji tímto, že maso a výrobky z masa, zde popsané, pocházejí ze skotu, ovčí, vepřů neb koz, které byly před i po porážce veterinářem prohlédnuty a že toto maso nebo tyto výrobky z masa jsou zdravé, zdravotně bezzávadné, zdraví prospěšné a i jinak způsobilé k lidské výživě, dále že nebyly upravovány konzervovadly a barvivy a že neobsahují těchto látek ani jiných, které nejsou dovoleny předpisy o kontrole masa, vydanými Departementem zemědělství Spojených států severoamerických a konečně, že tímto masem anebo výrobky z masa bylo v Československu nakládáno jen způsobem zdravotně nezávadným.

Druh zboží	Počet kusů nebo zásilek	Váha

Označení totožnosti na mase a obalech:

Jméno a adresa dodavatele:

Jméno a adresa příjemce:

Značky dopravní:

Úřední razítko

.....
(Podpis a hodnost veterináře prohlídkou pověřeného)

CZECHOSLOVAKIA



REPUBLIKA CESHOSLOVENSKÁ.

Úřední potvrzení o prohlídce vepřového masa a výrobků z něho.

Místo..... Československo. Datum..... 19.....

* Potvrzuji tímto, že zboží zde popsané, jest toho druhu, jak bývá upravováno k jídlu bez vaření, že obsahuje vepřové maso, které bylo v čerstvém nebo čerstvě nasoleném stavu chováno po dobu ne kratší než 20 dnů při teplotě ne vyšší než 5° Fahrenheita (– 15°C), nebo s nímž bylo jinak nakládáno tak, jak předepsáno přednostou Bureau of Animal Industry Spojených Států Severoamerických, a že toto zboží neobsahuje vepřové maso, kterým by bylo naloženo jiným způsobem, než jak je zde uvedeno.

Druh zboží	Počet kusů nebo zářilek	Váha

Označení totožnosti na masě a obalech:.....

Jméno a adresa dodavatele:.....

Jméno a adresa příjemce:.....

Značky dopravní:.....

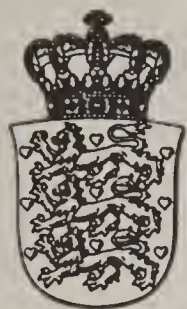
Úřední razítka.

(Podpis a hodnost veterináře prohlídkou pověřeného.)

Poznámka: Toto úřední potvrzení musí provázeti každou zářilku vepřového masa a výrobků, připravených k jídlu bez dodatečného vaření (uzenina, «italian» a «Westphalia» šunky a pod.). Toto úřední potvrzení musí být předloženo příjemcem nebo jeho zástupcem inspektorovi Departmentu zemědělství při prohlídce ve Spojených Státech.

Ch. 416.
Seřazené v Praze 6084-1936.

DENMARK



KINGDOM OF DENMARK

Ministry of Agriculture

Veterinary Department

Official meat-inspection certificate.City:
(By), DENMARK
(DANMARK)Date:
(Dato)

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine, or goats which received ante-mortem and post-mortem veterinary inspections at the time of slaughter, and that such meat and meat food products are sound, healthful, wholesome, and otherwise fit for human food, and have not been treated with, and do not contain, any preservative, coloring matter, or other substance not permitted by the regulations governing the meat inspection of the Danish Ministry of Agriculture, and that said meat and meat food products have been handled only in a sanitary manner in this country.

(Jeg attesterer herved, at nedenfor beskrevne kød og kødprodukter stammer fra kvæg, får, svin eller geder, som blev underkastet veterinærkontrol umiddelbart før og umiddelbart efter slagtningen, og at nævnte kød og kødprodukter er sunde og tjenlige til menneskeføde og ikke er behandlet med eller indeholder noget konserveringsstof, farvestof eller andet stof, som ikke er tilladt i de af det danske landbrugsministerium fastsatte bestemmelser om kødkontrol, samt at nævnte kød og kødprodukter her i landet udelukkende er behandlet på en hygiejnisk måde.)

Kind of product:
(Varens art)Number of pieces or packages:
(Antal colli)Gross-weight:
(Bruttovægt)Net-weight:
(Nettovægt)Identification marks on meats and packages:
(Veterinære kontrolmærker på kød og emballage)Consignor:
(Afsender)Address:
(Adresse)Consignee:
(Modtager)Destination:
(Bestemmelsessted)Shipping marks:
(Afsenderens fragtmærker)

Veterinary surgeon authorized by the Ministry of Agriculture.
(Dyrlæge autoriseret af landbrugsministeriet)

DENMARK



KINGDOM OF DENMARK

Ministry of Agriculture

Veterinary Department

Official meat-inspection certificate for pork and pork products

(For shipment to the United States of articles of a kind prepared customarily to be eaten without cooking, which contain muscle tissue of pork).

(For forsendelse til U. S. A. af varer af en art, således tilberedte, at de sædvanligvis spises uden forudgående kogning eller stegning, og som indeholder muskeltvæv af svin).

City:
(By)

, DENMARK
(DANMARK)

Date:
(Dato)

I hereby certify that the article or articles herein described are of a kind prepared customarily to be eaten without cooking, and contain muscle tissue of pork which, when fresh or freshly cured in salt, were subjected to a temperature not higher than 5° F. for not less than 20 days, or otherwise treated as specified by the Chief of the Bureau of Animal Industry, and that said articles contain no muscle tissue of pork which has not been treated as herein specified.

(Jeg attesterer herved, at varen eller varerne beskrevet heri er af en art, således tilberedt, at de sædvanligvis spises uden forudgående kogning eller stegning, og indeholder muskeltvæv af svin, som i fersk eller let saltet tilstand blev underkastet en temperatur ikke højere end 5° F (\div 15° C) i ikke mindre end 20 dage, eller behandlet på anden måde, som foreskrevet af the Chief of the Bureau of Animal Industry, og at nævnte varer ikke indeholder noget muskeltvæv af svin, der ikke er blevet behandlet efter nævnte forskrifter).

Kind of product:
(Varens art)

Number of pieces or packages:
(Antal colli)

Gross-Weight:
(Bruttovægt)

Net-Weight:
(Nettovægt)

Identification marks on meats and packages:
(Veterinære kontrolmærker på kød og emballage)

Consignor:
(Afsender)

Address:
(Adresse)

Consignee:
(Modtager)

Destination:
(Bestemmelsested)

Shipping marks:
(Afsendernes fragtmærker)

Veterinary surgeon authorized by the Ministry of Agriculture.
(Dyrlæge autoriseret af landbrugministeriet).

Form. B-43



REPUBLICA DOMINICANA
SECRETARIA DE ESTADO DE SALUD Y PREVISION SOCIAL

CERTIFICADO OFICIAL DE INSPECCION DE CARNE
Y PRODUCTOS DERIVADOS, PARA LA EXPORTACION.

Núm. _____

Santo Domingo,
Distrito Nacional, Rep. Dom.

_____ Fecha

CERTIFICO: Que las carnes y productos alimenticios de carnes aqui descritos, proceden de reses, carneros, cerdos o cabras que recibieron al tiempo del sacrificio inspecciones veterinarias ante-morten y post-morten; que dichas carnes y productos son sanos, saludables y apropiados para la alimentación humana; que no han sido tratados con, ni contienen ningún preservativo, materia colorante u otras sustancias no permitidas por el Reglamento oficial de la Secretaría de Estado de Salud y Previsión Social, de la República Dominicana, que rige la inspección de carnes; y que dichas carnes y productos han sido manipulados de manera sanitaria en este país.

Clase de producto.	Número de piezas o paquetes	Peso.
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

Señales de identificación en carnes y paquetes _____

Embarcador _____ Dirección _____

Consignatario _____ Destino _____

Marcas de embarque _____

Firma _____

Nombre

Médico Veterinario de la Secretaría de Estado de Salud
y Previsión Social.

ENGLAND AND WALES

FORM A



ENGLAND AND WALES
MINISTRY OF AGRICULTURE, FISHERIES AND FOOD

INSPECTION CERTIFICATE for use in connection with the
EXPORT OF MEAT AND MEAT PRODUCTS TO U.S.A.

Place..... Date

I HEREBY CERTIFY that the meat*/meat food products* described overleaf was/were derived from animals which received ante and post-mortem veterinary inspection at the time of slaughter and is/are sound, wholesome and fit for human consumption, and has/have not been treated with and does/do not contain any prohibited preservative or colouring matter, and that the said meat*/meat products* has/have been handled only in a hygienic manner in this country.

Official Certificate
authorised by
the Ministry of
Agriculture, Fisheries
and Food.

Signature.....
Certifying Officer

Official Title

* Delete when not applicable.
P.T.O.

REVERSE

<u>Description</u>	<u>No. of Package</u>	<u>Weight</u>
--------------------	-----------------------	---------------

Identification Marks.....

Name and address of Consignor

Name and address of Consignee

Conveyed by (Shipping Marks)

FINLAND

V:o _____

Kannosementillä lähetettävä todistus.
Intyg att bifogas kannosementet.SUOMEN
TASAVALTAREPUBLICEN
FINLANDMAATALOUSMINISTERIO — LANTBRUKSMINISTERIET
ELAINLÄÄKINTOOSASTO — VETERINÄRAVDELNINGEN

Lihantarkastustodistus. — Köttkontrollintyg.

_____ päivänä _____ kuuta 19____
(paikka)
_____ 19____
(ort) (nd)

Täten todistetaan, että allamainittu liha tai allamainitut lihatuotteet on saatu
Härmed intygas, att nedannämnt kött eller nedannämnda köttprodukter erhållits
eläinlääkäriin sekä ennen teurastusta että sen jälkeen tarkastamista eläimistä ja että
från djur, som undersökts av veterinär såväl före som efter slaktningen och att $\frac{de}{de}$ i
 $\frac{se}{ne}$ on hyväksytty voimassaolevan lihentarkastuslain mukaisessa järjestyksessä ihmisen
den ordning gällande köttkontrollag föreskriver, godkänts att såsom tjänlig $\frac{t}{a}$ till mäs-
ravinnoksi kelvollisena maasta vietäväksi,
niskoföda utföras ur landet.

Tavaralaji Varuslag	Köttens lukumäärä Antalet köttyn	Paino Vikt

Lihan ja päällysten tunnusmerkit:
Köttets och emballagens kännetecken:

Lähettiläjä:

Avsändare:

Vastaanottaja:

Emottagare:

Lähettiläsmistapa:

Transportsätt:

Osoite:

Adress:

Määräpaikka:

Destinationsort:

(Lähtävän nimi y.m.)
(Förtygats namn m.m.)

Lihantarkastaja tai terveydenhoitolaitoksen valtuutettu.
Köttkontrollör eller hälsöförordnad myndig.

FRANCE

(FACE)

RÉPUBLIQUE FRANÇAISE

MINISTÈRE DE L'AGRICULTURE

CERTIFICAT DU SERVICE OFFICIEL DE L'INSPECTION DES VIANDES

Lieu : _____ Date : _____
(ville) (pays)

Je certifie par la présente que la viande et les produits d'alimentation carnée décrits ci-dessous au verso proviennent d'animaux des espèces bovine, ovine, porcine ou caprine qui ont été soumis « ante-mortem » et « post-mortem » à des inspections du service vétérinaire au moment de l'abatage, que cette viande et ces produits d'alimentation carnée sont parfaitement sains et irréprochables au point de vue hygiénique et à tous autres égards propres à la consommation humaine, qu'ils ne renferment et n'ont été traités avec aucune matière préservatrice ou colorante ou autre substance non autorisée par les règlements relatifs à l'inspection des viandes sous le contrôle du Ministère de l'Agriculture des États-Unis d'Amérique, règlements enregistrés à mon service, et que ladite viande et lesdits produits d'alimentation carnée n'ont été manipulés dans ce pays qu'avec toutes les précautions sanitaires désirables.

FRANCE

(REVERSE)

NATURE DU PRODUIT	NOMBRE DE MORCEAUX ou de colis	POIDS
-------------------	-----------------------------------	-------

Marques d'identification sur les viandes et les colis : _____

Expéditeur : _____ Adresse : _____

Destinataire : _____ Lieu de destination : _____

Marques d'expédition : _____

Signature :

*Vétérinaire Inspecteur agréé par le Ministère
de l'Agriculture de la République Française*

Contrescoring du
Directeur Départemental des
Services Vétérinaires

GERMANY (FEDERAL REPUBLIC)

Ausländisches amtliches Fleischuntersuchungs-Zertifikat

Ort Datum
 (Stadt) (Land)

Ich bescheinige, daß das unten beschriebene Fleisch und Fleischprodukt vom Rind, Schaf, Schwein oder Ziege stammt. Die Tiere wurden einer amtlichen Schlachtvieh- und Fleischschau unterzogen. Das Fleisch und die Fleischprodukte sind fehlerfrei, gesund, bekömmlich und für den menschlichen Genuß geeignet. Sie enthalten keine Konservierungsmittel, Farben oder sonstige Substanzen, die laut Verfügung der Fleischschauabteilung des amerikanischen Landwirtschaftsministeriums, die in meinem Besitz ist, verboten sind. Das Fleisch und die Fleischprodukte sind in diesem Land nur hygienisch einwandfrei behandelt worden.

Art des Produktes	Zahl der Stücke oder Kalli	Gewicht
.....
.....
.....
.....

Identifizierungsmarkierungen
 auf dem Fleisch und den Kalli



Verfrachter
 Adresse
 Empfänger
 Bestimmungsart
 Versandmarkierungen

(Unterschrift)
 (Name des Beamten der ausländischen Regierung, der berechtigt ist, Untersuchungszertifikate auszufertigen für Fleisch und Fleischprodukte, die für den Export nach den USA bestimmt sind.)

(Amtlicher Titel)



Dienstiegel des mit der
 Überwachung beauftrag-
 ten beamteten Tierarztes.

Amtliches Fleischuntersuchungs-Zertifikat für Schweinefleisch und Schweinefleischprodukte

(Für den Versand nach den USA von Waren, die Muskelgewebe des Schweines enthalten und die im allgemeinen ohne vorheriges Kochen verzehrt werden.)

Ort Datum 196.....

Ich bescheinige, daß die Ware, die unten angeführt ist, im allgemeinen ohne vorheriges Kochen verzehrt wird und Muskelgewebe des Schweines enthält. Die Ware wurde in frischem oder frischgepökeltem Zustand wenigstens zwanzig Tage lang einer Temperatur von höchstens 5° F ausgesetzt oder in Übereinstimmung mit einer Anweisung des Leiters der amerikanischen Fleischschauabteilung behandelt. Diese Ware enthält keine Schweinemuskelgewebe, die nicht wie beschrieben behandelt worden sind.

Art des Produktes	Zahl der Stücke oder Kalli	Gewicht
.....
.....
.....

Identifizierungsmarkierungen
 auf dem Fleisch und den Kalli



Verfrachter
 Adresse
 Empfänger
 Bestimmungsart
 Versandmarkierungen

(Unterschrift)
 (Name des Beamten der ausländischen Regierung, der berechtigt ist, Untersuchungszertifikate auszufertigen für Fleisch und Fleischprodukte, die für den Export nach den USA bestimmt sind.)

(Amtlicher Titel)

Anmerkung: Obiges Zertifikat wird für jede Konsignation verlangt, die aus Produkten besteht, die gewöhnlich ohne vorheriges Kochen verzehrt werden (z. B. Cervelatwurst, Italienischer oder Westfälischer Schinken und dergl.) und die Schweinemuskelgewebe enthalten. Dieses Zertifikat muß von dem Empfänger oder dessen Agenten der Fleischschauabteilung am Untersuchungsort in den USA übergeben werden.



Dienstiegel des mit der
 Überwachung beauftrag-
 ten beamteten Tierarztes.

GUATEMALA



Nº 006

Perm. Exp. No. _____

REPUBLICA DE GUATEMALA

Ministerio de Salud Pública y Asistencia Social

DIRECCION GENERAL DE SANIDAD

CERTIFICADO OFICIAL DE INSPECCION DE CARNES

FOREIGN OFFICIAL MEAT INSPECTION CERTIFICATE

Lugar _____
(PLACE)Fecha _____
(DATE)

Yo certifico por el presente, que la carne o producto comestible de carne aquí descrito, derivan de animales que recibieron inspección veterinaria ante-mortem y post-mortem al tiempo de sacrificarse; y que dicha carne y producto comestible de carne son buenos, sanos y apropiados para el consumo humano; y que no han sido tratados ni contienen ningún preservativo, sustancias colorantes u otras sustancias no permitidas por el Departamento de Agricultura de los Estados Unidos; y que han sido manipulados estrictamente en forma sanitaria en este país.

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine, or goats which received ante-mortem and post-mortem veterinary inspections at the time of slaughter, and that such meat and meat food products are sound, healthful, wholesome, and otherwise fit for human food, and have not been treated with, and do not contain, any preservative, coloring matter or other substance not permitted by the regulations governing the meat inspection of the United States Department of Agriculture, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

ARTICULOS (Kind of Product)	NUMERO DE PIEZAS O BULTOS (Number or pieces or packages)	PESO (Weight)

Marcas de Identificación de la Carne y Bultos _____

-IDENTIFICATION MARKS ON MEATS PACKAGES-

Vapor _____

-STEAMER S. S.-

Embarcador _____

-CONSIGNOR-

Dirección _____

-ADDRESS-

Consignatarios _____

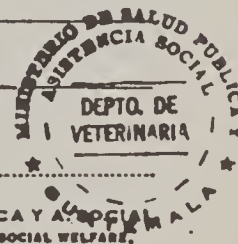
-CONSIGNEE-

Destino _____

-DESTINATION-

Marcas de Embarque _____

-SHIPPING MARKS-



MEDICO VETERINARIO
AUTORIZADO POR EL MINISTERIO DE SALUD PUBLICA Y ASISTENCIA SOCIAL
D. V. M. AUTHORIZED BY THE MINISTRY OF PUBLIC HEALTH AND SOCIAL WELFARE.

HAITI



REPUBLIQUE D'HAITI

DEPARTEMENT DE LA SANTE PUBLIQUE ET DE LA POPULATION

**CERTIFICAT DU SERVICE OFFICIEL
DE L'INSPECTION DES VIANDES**

 Lieu.....
(Place)

 Date.....
(Date)

Par la présente je certifie que la viande ou les produits d'alimentation à base de viande ci-dessous décrits viennent de bestiaux, moutons, porcs ou chèvres qui ont été soumis à une inspection vétérinaire avant et après l'abattage et que cette viande et ces produits alimentaires à base de viande sont sains, salubres, en bon état et propres à l'alimentation humaine qu'ils n'ont pas été traités à l'aide de et qu'ils ne contiennent aucun préservatif, matière colorante ou autre substance non permis par les règlements du Département de la Santé Publique d'Haïti ayant trait à l'inspection de la viande, qu'ils ont été enregistrés en ma présence et que la dite viande et les dits produits alimentaires à base de viande ont été traités selon les règlements sanitaires en vigueur dans ce pays.

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine, or goats which received antemortem and postmortem veterinary inspection at the time of slaughter, and that such meat and meat food products are sound, healthful, wholesome, and otherwise fit for human food, and have not been treated with, and do not contain any preservative, coloring matter, or other substance not permitted by the regulations governing the meat inspection of Haiti's Direction of Public Hygiene, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

ARTICLE (Kind of product)	NOMBRE DE PIÈCES OU PACKETS (Number of pieces or packages)	POIDS (Weight)

 Marque d'Identification sur la viande et les packets
(Identification Marks on Meats and Packages)

Via :

 Consignataire..... Adresse.....
(Consigner) (Address)

 Destinataire..... Destination.....
(Consignee) (Destination)

 Marques d'expédition.....
(Shipping Marks)

(35415)

 Vétérinaire Inspecteur
agré par le Ministère de la Santé Publique
et de la Population



Nº 0750

REPUBLICA DE HONDURAS, C. A.
SECRETARIA DE ESTADO EN EL DESPACHO DE RECURSOS NATURALES

CERTIFICADO OFICIAL DE INSPECCION DE CARNES

Lugar _____
(Place)

Fecha _____
(Date)

Se certifica por el presente, que la carne o producto comestible de carne aquí descrito, derivan de animales que recibieron inspección veterinaria ante-mortem y post-mortem al tiempo de sacrificarse; y que dicha carne y producto comestible de carne son buenos, sanos y apropiados para el consumo humano; y que no han sido tratados ni contienen ningún preservativo, sustancias colorantes u otras sustancias prohibidas por la Ley y Reglamento para la Industrialización Sanitaria de la Carne de Honduras; y que han sido manipulados en forma sanitaria en este país

This is certify that the meat or meat food products here in described were derived from animals which received ante-mortem and post-mortem veterinary inspection at the time of slaughter, and that said meat and meat food products are sound, healthful, wholesome and ohterwise fit for human food, and have not been treated with and do not contain any preservative, coloring matter, or other substance not permitted by the Meat Inspection Act and Regulations of Honduras, and have been handled only in a sanitary manner in this country.

12 B. XII-66 Imp. Honduras

ARTICULOS (KING OF PRODUCTS)	ORIGEN (ORIGEN)	NUMERO DE PIEZAS O BULTOS (NUMBER OF PIECES OR PACKAGES)	PESO (WEIGHT)

Marcas de Identificación de la Carne y Bultos _____
(Identification Marks on Meats and Packages)

Via _____

Embarcador _____
(Consignor)

Dirección _____
(Address)

Consignatarios _____
(Consignee)

Dirección _____
(Address)

Destino _____
(Destination)

Marcas de Embarque _____
(Shipping Marks)

MEDICO VETERINARIO
Autorizado por el Ministerio de Recursos Naturales
(Veterinary Inspector authorized by the Secretary of Natural Recources)

ICELAND



REPUBLIC OF ICELAND
DEPARTMENT OF AGRICULTURE

OFFICIAL MEAT-INSPECTION CERTIFICATE

....., Iceland,

. 19

I HEREBY certify that the meat ^{and} ~~or~~ meat food-products hereunder described ^{was} ~~were~~ derived from animals subjected to ante- and post-mortem veterinary inspection at the time of slaughter and found to be free from disease and suitable in every way for human consumption, and that ^{it has not} ~~they have not~~ been treated with chemical preservatives or other foreign substances injurious to health.

Kind of product	Number of Parcels	Brand or mark	Where slaughtered	Consignor	Consignee
.....
.....
.....
.....
.....
.....
.....
.....

Signature.

Government Veterinarian

9462(M)

IRELAND



DEPARTMENT OF AGRICULTURE, IRELAND.

Meat Inspection Certificate.

Place Ireland. Date

I hereby certify that the meat and meat food products described below were derived from cattle, sheep or swine, which received ante-mortem and post-mortem veterinary inspections at the time of slaughter and are sound, healthful, wholesome and otherwise fit for human food and have not been treated with and do not contain any prohibited preservative or colouring matter and that the meat and meat food products have been handled only in a sanitary manner in this country.

Kind of Product	Number of Pieces or Packages	Weight
.....
.....
.....
.....

Date of Shipment :

Consignor :

Address :

Consignee :

Address :

Shipping Marks :

Identification Marks : OFFICIAL INSPECTION STAMP.

(Signature) M. R. C. V. S.

Official Title
Department of Agriculture.

ITALY

MOD. 23

MODULARIO
Sanità - 86



REPUBBLICA ITALIANA

MINISTERO DELLA SANITÀ SERVIZIO VETERINARIO

N° 0009014

Stabilimento di produzione

INDICAZIONE DEL PRODOTTO CHE SI ESPORTA

Si certifica che la carne o i prodotti di carne a fianco indicati

spediti da (1)

e diretti a (2)

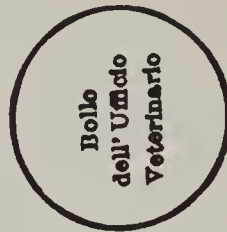
provengono da animali che, a norma delle disposizioni vigenti nella Repubblica, sono stati, prima e dopo la macellazione, sottoposti a visita sanitaria e riconosciuti sani; si certifica inoltre che la carne o i prodotti di carne suddetti sono stati, a norma delle citate disposizioni, sottoposti a visita sanitaria e riconosciuti sani e atti al consumo.

19.....

- (1) Nome e cognome della persona che spedisce e luogo di origine della merce.
- (2) Nome e cognome del destinatario e luogo di destinazione.



IL VETERINARIO
DI CONFINE O DI PORTO



ITALY

Mod. 2846

REPUBBLICA ITALIANA

ALTO COMMISSARIATO PER L'IGIENE E LA SANITA' PUBBLICA

SERVIZIO VETERINARIO

Certificato complementare per la esportazione negli Stati Uniti d'America delle carni e prodotti di carni suine contenenti tessuto muscolare, preparati secondo le abituali regole per essere consumati senza cottura.

N. d'ordine

Il sottoscritto dichiara che il prodotto od i prodotti qui sotto specificati sono stati preparati nei modi consueti per essere consumati senza cottura, e che contengono tessuto muscolare di maiale, il quale, allo stato fresco, o dopo recente salatura, è stato mantenuto ad una temperatura non superiore a 5 gradi Fahrenheit per non meno di 20 giorni

<i>Qualità dei prodotti</i>	<i>Num. dei pezzi e dei colli</i>	<i>Peso</i>
.....
.....
.....

Marchio di identificazione apposto sulle carni o sugli imballaggi

Speditore *Indirizzo*

Destinatario *Destinazione*

Luogo e data di rilascio del certificato



Il Veterinario governativo di confine o di porto



J A P A N

MINISTRY OF HEALTH AND WELFARE

MEAT-INSPECTION CERTIFICATE

No. _____

Place _____
(City) (Country)

Date _____

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine, or goats which received ante-mortem and post-mortem veterinary inspections at the time of slaughter, and that such meat and meat food products are sound, healthful, wholesome, and otherwise fit for human food, and have not been treated with, and do not contain, any preservative, coloring matter, or other substance not permitted by the regulations governing the meat inspection of the United States Department of Agriculture, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country and the meat products were prepared only in the following approved establishments: _____.

Kind of product	Number of pieces or packages	Weight
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

Identification Marks on meats and packages _____

Consignor _____

Address _____

Consignee _____

Designation _____

Shipping marks _____

(Signature) _____
 (Name of official of national government authorized to
 issue inspection certificates for meat and meat food
 products exported to the United States)
 (Official title) _____

MEXICO

Forma Núm. 15



Certificado No. _____

REPUBLICA MEXICANA
SECRETARIA DE AGRICULTURA Y GANADERIA
DIRECCION GENERAL DE GANADERIA

EXPORTACION A: _____

CERTIFICADO
DE INSPECCION DE CARNE Y SUS DERIVADOS COMESTIBLES

(LUGAR)

(FECHA)

Se certifica que la carne y derivados comestibles de la misma, detallados en este Certificado, proceden de animales que han sido sometidos a inspección sanitaria veterinaria federal, antes, durante y después de sacrificados, en los términos de la Ley de 31 de diciembre de 1949, y que dicha carne y derivados alimenticios han sido encontrados en perfectas condiciones higiénicas y buenos en absoluto para el consumo humano. Se certifica también que no contienen ni han sido tratados con ningún preservativo, materia colorante, ni otras sustancias prohibidas por la Ley antes citada.

MARCAS DE IDENTIFICACION EN LAS CARNES O BULTOS	
Nombre del Establecimiento, T.I.F. Productor:	Vía:
Número de Registro:	Destino:
Remitente:	Consignatario:
Procedencia:	Marcas de Embarque:
Detalle del Cargamento:	

(Firma del Funcionario Federal autorizado)

(Sello de la Direc. Gral. de Ganadería)

MEXICO

Forma Num. 21

Certificado



REPUBLICA MEXICANA
SECRETARIA DE AGRICULTURA Y GANADERIA
DIRECCION GENERAL DE GANADERIA

EXPORTACION A: _____

CERTIFICADO

DE INSPECCION DE CARNE DE CERDO Y SUS DERIVADOS
COMESTIBLES

(LUGAR)

(FECHA)

Se certifica que el producto o productos comestibles que se detallan en este Certificado están preparados en la forma usual para comerse sin nuevo o ulterior cocimiento y contienen carne de cerdo, la cual, cuando fresca o durante el proceso de curación se sujetó a una temperatura no más alta de menos 15° C. (5° F.), durante un período no menor de 20 días, o bien fueron tratados de acuerdo con lo prescrito por el Jefe de la División de la Inspección Sanitaria de la Carne; certificándose también que no contienen carne de cerdo que haya sido tratada de manera diferente a la especificada anteriormente.

MARCAS DE IDENTIFICACION EN LAS CARNES O BULTOS	
Nombre del Establecimiento T.I.F. Productor:	Via:
Número de Registro:	Destino:
Remitente:	Consignatario:
Procedencia:	Marcas de Embarques:
Detalle del Cargamento:	

(Firma del Funcionario Federal autorizado)

(Sello de la Direc. Genl. de Ganaderia)

NETHERLANDS

16305 * ORIGINAL

KINGDOM OF THE NETHERLANDS
MINISTRY OF AGRICULTURE AND FISHERIES
VETERINARY SERVICES

OFFICIAL MEAT INSPECTION CERTIFICATE OF COUNTRY OF SLAUGHTER

Place: _____ Date: _____

I hereby certify that the meat and meat food products herein described were derived from cattle, sheep, swine or goats which received ante-mortem and post-mortem veterinary inspection at the time of slaughter and that such meat and meat food products are sound, healthy, wholesome and otherwise fit for human food and have not been treated with, and do not contain any preservative, colouring matter, or other substance not permitted by the regulations governing the meat inspection of the United States Department of Agriculture, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

Kind of product: _____ Number of pieces and packages: _____ Weight: _____

Identification mark on meat and packages: _____

Consignor: _____ Address: _____

Consignee: _____ Destination: _____

Shipping mark: _____

VETERINARY OFFICER AUTHORIZED BY THE
MINISTRY OF AGRICULTURE AND FISHERIES

Model 3 109758 LV 236.6

ORIGINAL

KINGDOM OF THE NETHERLANDS
MINISTRY OF AGRICULTURE AND FISHERIES
VETERINARY SERVICES

OFFICIAL MEAT INSPECTION CERTIFICATE FOR PORK AND PORK PRODUCTS

(For inspection of the United States articles of food prepared customarily to be eaten without cooking, which contain muscle tissue of pork)

Place: _____ Date: _____

I hereby certify that the article or articles herein described are of a kind prepared customarily to be eaten without cooking, and contain muscle tissue of pork which, when fresh or freshly cured in salt, were subjected to a temperature not higher than 150 degrees F. for not less than twenty (20) days or otherwise treated as specified by the Chief of the Meat Inspection Division, and that said articles contain no muscle tissue of pork which has not been treated as herein specified.

Kind of product: _____ Number of pieces and packages: _____ Weight: _____

Identification mark on meat and packages: _____

Consignor: _____ Address: _____

Consignee: _____ Destination: _____

Shipping mark: _____

VETERINARY OFFICER AUTHORIZED BY THE
MINISTRY OF AGRICULTURE AND FISHERIES

Model 2 907498

Ag.L. 190

Department Of Agriculture

No:.....



OFFICIAL MEAT - INSPECTION CERTIFICATE

_____, New Zealand

19_____

I HEREBY certify that the meat ^{and} _{or} meat food-products hereunder described ^{was} _{were} derived from animals subjected to ante- and post-mortem veterinary inspection at the time of slaughter and found to be free from disease and suitable in every way for human consumption, and that ^{it has not} _{they have not} been treated with chemical preservatives or other foreign substances injurious to health.

Consignor:		Consignee:	
Port of Loading:	Vessel:	Port of Destination:	
Ultimate Destination:		Slaughtered at:	
Marks and Brands	Number of Packages	Description of Goods	lbs. Net Weight

(Revised 1/2/63)

 Signature: _____
 Veterinary Officer. New Zealand Government.

MINISTRY OF AGRICULTURE FOR NORTHERN IRELAND



INSPECTION CERTIFICATE
for use in connection with the
EXPORT OF MEAT AND MEAT PRODUCTS

Place..... Date.....

I HEREBY CERTIFY that the meat and/or meat food products herein described was/were derived from animals which received ante and post-mortem veterinary inspection at the time of slaughter and are sound, wholesome and fit for human consumption, and have not been treated with and do not contain any prohibited preservative or colouring matter, and that the said meat and/or meat products have been handled only in a sanitary manner in this country.

<u>Description</u>	<u>No. of Package</u>	<u>Weight</u>
--------------------	-----------------------	---------------

Identification Marks

Name and Address of Consignor

Name and Address of Consignee

Conveyed by (Shipping Marks)

Signature M.R.C.V.S.
Certifying Officer

Official Title.....Veterinary Officer

NORWAY



KONGERIKET NORGE

LANDBRUKSDEPARTEMENTET — VETERINÆRDIREKTORATET

Kingdom of Norway
Ministry of Agriculture
Veterinary directorate

Königreich Norwegen
Landwirtschaftsministerium
Veterinärdirektorat

Royaume Norvège
Ministère de l'agriculture
Directoire vétérinaire

Reino Noruega
El Ministerio de Agricultura
Dirección de veterinaria

Opprinnelses- og sunnhetsattest

*Certificate of Origin and Health / Ursprungs- und Gesundheitszeugnis
Certificat d'origine et de sante / Certificado de origen y de sanidad*

Avsenderens navn og adresse .

*Name and address of consignor / Name und Anschrift des Absenders / Nom et adresse de l'expéditeur /
Nombre y dirección del consignante*

Mottakerens navn og adresse

*Name and address of consignee / Name und Anschrift des Empfängers / Nom et adresse du destinataire /
Nombre y dirección del consignatario*

Varens art / *Description of goods / Warenart / Nature de la Marchandise / Naturaleza de la mercadería*

Antall kolli

*No. of pieces or packages / Stückzahl /
Nombre des colis / Número de bultos*

Avsenderens fraktmerke

*Shipping marks / Versandzeichen / Marques d'expédition /
Marcas de expedición del consignante*

Bruttovekt

Gross weight / Bruttogewicht / Poids brut / Peso bruto

Nettovekt

Net weight / Nettogewicht / Poids net / Peso neto

Veterinærens kontrollmerke på kjøtt og emballasje

Veterinary Inspection Markings on Packing or Meat

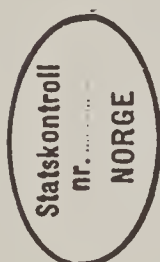
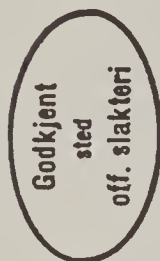
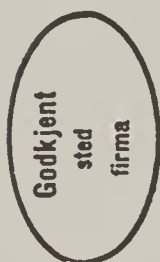
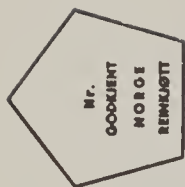
Tierärztliche Kontrollzeichen an der Verpackung bzw. am Fleisch

Marques de contrôle vétérinaire sur l'emballage ou sur la viande

Marcas del control veterinario en el embalaje o en la carne

Undertegnede norske veterinær, autorisert av Landbruksdepartementet, attesterer hermed at ovennevnte kjøtt eller kjøttvarer er av norsk opprinnelse og stammer fra dyr slaktet under offentlig tilsyn og underkastet veterinærundersøkelse umiddelbart før og etter slaktingen og funnet friske og fri for smittsomme sykdommer, at varene er friske og ubetinget godkjent til folkemat, at behandling, framstilling og pakking av varene er foregått under hygienisk forsvarlige forhold og under veterinært tilsyn, at varene ikke er behandlet med eller tilsatt konserveringsmidler, fargestoffer eller andre stoffer som er forbudt etter eksport- eller importlandets bestemmelser og at varene er tillatt omsatt i Norge. Svinekjøtt er trikkkontrollert.

NORWAY



Norske veterinære kontrollmerker:
Norwegian Veterinary Inspection Markings:
Norwegische tierärztliche Kontrollzeichen:
Marques de contrôle vétérinaire norvégiennes:
Marcas de control veterinario noruegas:

I, the undersigned veterinary inspector, licensed by the Norwegian Ministry of Agriculture, do hereby certify that the above described shipment of meat or meat food products is of Norwegian origin and is derived exclusively from animals slaughtered under official supervision, and has been subjected to veterinary examination immediately before and after the slaughtering and found fresh and free from contagious diseases, that the commodities at the dispatch are sound and unconditionally fit for human consumption, that the commodities have been dealt with, produced and packed under sanitary conditions and under veterinary supervision, that the commodities have neither been treated with nor contains preservative, colouring matter, or other matter prohibited by Norwegian legislation or by the regulations of the importing country, and that the sale of these commodities for human consumption anywhere in Norway is permitted. Pork has been examined for trichinosis.

Unterzeichneter, vom Norwegischen Landwirtschaftsministerium autorisierter Veterinär, bestätigt hierdurch, dass die oben beschriebene Sendung an Fleisch bzw. Fleischprodukten norwegischen Ursprungs ist und ausschliesslich von Tieren stammt die unter öffentlicher Kontrolle geschlachtet, sowohl vor als nach dem Schlachten einer tierärztlichen Untersuchung unterzogen und dabei als gesund und von ansteckenden Krankheiten frei befunden wurden, dass die Ware beim Versand gesund und als menschliche Nahrung unbedingt geeignet ist, dass Behandlung, Herstellung und Verpackung der Ware unter hygienischen Verhältnissen sowie unter tierärztlicher Beaufsichtigung vorgenommen wurden, dass die Ware weder mit Konservierungs- und Farbstoffen bzw. mit anderen laut norwegischem Gesetz oder laut Gesetz des Einfuhrlandes verbotenen Stoffen behandelt ist, noch derartige Stoffe enthält, und dass der Vertrieb der Ware als menschliche Nahrung überall in Norwegen zulässig ist. Schweinefleisch ist auf Trichinen untersucht.

Je soussigné, vétérinaire public autorisé par le Ministère de L'Agriculture norvégien, certifie par la présente que le lot de viande ou de produits de viande ci-dessus indiqué est d'origine norvégienne et provient exclusivement d'animaux abattus sous contrôle public, soumis à l'examen vétérinaire immédiatement avant et après l'abatage et trouvés sains et exempts de maladies contagieuses; que, au moment de l'expédition, la marchandise est de bonne qualité sanitaire et absolument propre à la consommation et que le traitement, la préparation et l'emballage de la marchandise ont eu lieu dans des conditions hygiéniques sous surveillance vétérinaire; que la marchandise n'a pas été traité avec, ni ne contient, des matières colorantes ou autres matières dont l'usage est défendu par la législation norvégienne, ou par la législation du pays d'importation, et que la marchandise est admise à être livrée à la consommation partout en Norvège. Trichiniscopel avec résultat négatif.

Yo, el veterinario oficial suscrito, autorizado por El Ministerio de Agricultura certifico por la presente, que la partida de carne o de productos de carne arriba indicada es de origen noruego y que procede exclusivamente de animales carneados bajo control oficial y sometidos a examen veterinario inmediatamente antes de ser carneados, siendo encontrados sanos y libres de enfermedades contagiosas; que la mercadería al ser despachada estaba sana y absolutamente apta para el consumo humano; que la elaboración y el embalaje de la mercadería se han efectuado bajo condiciones higiénicas y vigilancia veterinaria; que la mercadería no ha sido tratada con, ni contiene sustancias de conservación ni colorantes, ni el tratamiento otra sustancia prohibida por la legislación noruega, o por la legislación en el país importador, y que su venta para el consumo humano está permitida en todas partes de Noruega. Cerdo ha sido controlado de triquina.

Sted og dato

Place and date / Ort und Tag / Lieu et date / Lugar y fecha

Tjenestestempel

Official stamp / Amtlicher Stempel /

Cachet / Bello oficial

Autorisert veterinærers underskrift

Signature of Licensed Veterinary Inspector / Unterschrift des autorisierten Veterinärs / Signature d'un médecin vétérinaire autorisé /

Firma del médico veterinario autorizado

PANAMA



REPUBLICA DE PANAMA
 MINISTERIO DE TRABAJO PREVISION SOCIAL Y SALUD PUBLICA
 DEPARTAMENTO DE SALUD PUBLICA
 SECCION VETERINARIA
CERTIFICADO OFICIAL DE INSPECCION DE CARNES

Lugar
 (Place)

Fecha
 (Date)

Se certifica por el presente, que la carne o sus derivados aquí descritos, proceden de animales que recibieron inspección veterinaria de ante-mortem y post-mortem al tiempo de sacrificarse; y que dicha carne y sus derivados son buenos, sanos y apropiados para el consumo humano; y que no han sido tratados ni contienen ningún preservativo; sustancias colorantes u otras sustancias prohibidas por el Decreto Nº 62, de 15 de Enero de 1957, Código Sanitario de Inspección y Vigilancia de Carnes; y que han sido manipulados en forma sanitaria en este país.

This is to certify that the meat or meat food products here in described were derived from animals which received ante-mortem and post-mortem inspection at the time of slaughter, by a graduate veterinarian, and that said meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with and do not contain any preservative, colorin matter, or other substance not permitted by Decree Number 62 of 15th of January, 1957, Sanitary Code for Inspection and Vigilance of Meats, and have been handled only in a sanitary manner in this country.

ARTICULOS (Kind of Products)	NUMERO DE PIEZAS O BULTOS (Number of Pieces or Packages)	PESO

Marcas de Identificación de la Carne y Bultos
 (Identification Marks on Meats and Packages)

Medio de Transporte
 (Carrier)

Embarcador Dirección
 (Consigner) (Address)

Consignatario Destino
 (Consignee) (Destination)

Marcas de Embarque
 (Shipping Marks)

.....
 Médico Veterinario

Autorizado por el Ministerio de Trabajo, Previsión Social
 y Salud Pública

D.V.M. Authorized by Ministry of Work, Social Welfare
 and Public Health

POLAND



POLSKA RZECZPOSPOLITA LUDOWA
MINISTERSTWO ROLNICTWA
 DEPARTAMENT WETERYNARII

ZAGRANICZNE URZĘDOWE ŚWIADECTWO BADANIA MIĘSA

Nr

Miejscowość

Data

Zaświadczam niniejszym, że mięso i przetwory mięsne niżej opisane, pochodzą z bydła rogatego, owiec, świń i kóz, poddanych przed ubojem i po uboju badaniu weterynaryjnemu oraz że to mięso i przetwory mięsne są zdrowe, nieszkodliwe i odpowiednie do spożycia przez ludzi, jak również, że do ich wyrobu nie były używane i nie są w nich zawarte żadne środki konserwujące, ani barwniki, ani inne substancje niedozwolone przez przepisy normujące sposób badania mięsa, wydane przez Departament Rolnictwa Stanów Zjednoczonych, jako też, że mięso to oraz przetwory mięsne zostały przygotowane tutaj w kraju w sposób zgodny z wymogami higieny.

Rodzaj przetworów

Ilość sztuk lub paczek (skrzyń)

Waga

Znaki rozpoznawcze na przetworach mięsnych lub paczkach (skrzyniach)

Nadawca

Odbiorca

Adres

Znaki transportowe

Miejsce przeznaczenia

 Podpis
 Nazwisko urzędnika upoważnionego do wystawiania świadectw (badania mięsa i przetworów mięsnych wywożonych do USA)

Tytuł urzędowy

POLAND



POLSKA RZECZPOSPOLITA LUDOWA
MINISTERSTWO ROLNICTWA
 CENTRALNY ZARZĄD WETERYNARII

**URZĘDOWE ŚWIADECTWO BADANIA MIĘSA WIEPRZOWEGO
 I PRZETWORÓW WIEPRZOWYCH**

(Na przesyłki morskie do U.S.A. artykułów przyrządzonych do spożycia bez gotowania
 a zawierających wieprzowinę)

Nr

Miejscowość

Data 19.....

Zaświadczam niniejszym, że artykuł lub artykuły opisane są przyrządzone do spożycia bez gotowania i zawierają tkanki mięsne wieprzowiny, które w stanie świeżym albo świeżo zapakowane w solance zostały poddane działaniu temperatury nie wyższej niż 5 °F (pięć) przez czas nie krótszy od dwadzieścia (20) dni lub były poddane jednemu z innych sposobów postępowania, wyszczególnionych przez Szefa Wydziału Inspekcji Mięsnej, jako też, że wymienione artykuły nie zawierają żadnych wieprzowych tkanek mięsnych, które nie były poddane postępowaniu wymienionemu w niniejszym świadectwie.

Rodzaj przetworów

Ilość sztuk lub paczek (skrzyń)

Waga

Znaki rozpoznawcze na przetworach mię-
 snych lub paczkach

Nadawca

Adres

Odbiorca

Miejsce przeznaczenia

Znaki transportowe

U W A G A : Świadectwo powyższej treści musi być dołączone do każdej przesyłki artykułów żywności przeznaczonych do spożycia bez gotowania (np. letnia kielbasa, włoska i westfalska szynka itp.), które zawierają jakieś tkanki mięsne wieprzowe.

Odbiorca lub jego agent winien świadectwo niniejsze doręczyć Inspektorowi Wydziału Inspekcji Mięsnej w miejscu badania w USA.

Podpis
 (Nazwisko urzędnika upoważnionego do wystawie-
 nia świadectw badania mięsa i przetworów mię-
 snych wywożonych do U.S.A.)

Tytuł urzędowy

FORM A



SCOTLAND

SCOTTISH HOME AND HEALTH DEPARTMENT

**CERTIFICATE for use in connection with the EXPORT OF MEAT AND
MEAT PRODUCTS**

Place..... Date.....

I HEREBY CERTIFY that the meat*/meat food products* described overleaf was/were derived from animals which received ante and post-mortem veterinary inspection at the time of slaughter and is/are sound, wholesome and fit for human consumption, and has/have not been treated with and does/do not contain any prohibited preservative or colouring matter, and that the said meat*/meat products* has/have been handled only in a hygienic manner in this country.

Signature.....
Certifying Officer

Official Title.....
Authorised Officer for the Burgh of
County

Official Certificate
authorised by the
Secretary of State for Scotland.

.....
*Delete when not applicable.

P.T.O.

SPAIN

E S P A Ñ A

MINISTERIO DE LA GOBERNACION

DIRECCION GENERAL DE SANIDAD



SERVICIOS DE SANIDAD VETERINARIA

**Documento sanitario para la exportación de productos alimenticios de origen animal
con destino a los Estados Unidos**

Nación

Provincia

Municipio

Por el presente certifico que la carne y los productos cárnicos alimenticios que aquí se describen proceden de reses que fueron objeto de inspección veterinaria antes y después de su sacrificio en los Mataderos Oficiales autorizados y que dicha carne y productos cárnicos se hallan en buenas condiciones de salubridad, siendo aptos para el consumo humano, sin que hayan sido tratados ni contengan sustancias preservativas, colorantes o alguna otra prohibida por las disposiciones que regulan la inspección cárnica de los Estados Unidos, Departamento de Agricultura, y que dicha carne y productos cárnicos han sido tratados en este país únicamente por procedimientos sanitarios.

CLASE DE LA MERCANCIA

PIEZAS O NÚMERO
DE PAQUETES

P E S O



Remitente

Domicilio

Consignatario

Destino

Marcas de identificación sobre carnes y paquetes

Marcas de facturación

a

de

de 195

V.º B.º

EL VETERINARIO DE SANIDAD EXTERIOR,

EL VETERINARIO OFICIAL,

VETERINÄRINTYG FÖR KÖTTEXPORT
KINGDOM OF SWEDEN
 The National Swedish Veterinary Board



Official meat-inspection certificate

Place (avsändningsort)

Date (datum och år)

I hereby certify that the meat or meat food products herein described were derived from animals (cattle, sheep, swine, goats) which received ante-mortem and post-mortem veterinary inspections at the time of slaughter, and that such meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with, and do not contain, any preservative, coloring matter or other substance not permitted by the regulations governing the meat inspection of the United States Department of Agriculture, filed with me, and that said meat and meat food products have been handled only in a sanitary manner in this country.

Undertecknad intygar härmed att nedan angivna köttvaror härröra från djur (nötkreatur, får, svin, get), vilka undergått veterinärbesiktning omedelbart före och omedelbart efter slakten, att desamma äro tjänliga till människoföda, att de icke hava behandlats med eller innehålla förbjudna konserveringsmedel, färg, eller andra ämnen, som icke äro tillåtna enligt amerikanska jordbruksdepartementets bestämmelser rörande köttkontroll, samt att desamma här i landet hava behandlats på ett i sanitärt avseende tillfredsställande sätt.

Kind of product. (Varuslag)	Number of pieces or packages. (Antal köll)	Weight. (Vikt)
.....
.....
.....

Identification marks on meats and packages
 (A kött eller emballage anbragta veterinära kontrollmärken)

Consignor Address
 (Avsändare)

Consignee Destination
 (Mottagare) (Adressort)

Shipping marks
 (Avsändarens befraktningsmärken)

(Signature)
 Veterinary inspector authorized by the National Swedish Veterinary Board.
 Av Kungl. Veterinärstyrelsen förordnad besiktningsveterinär.



Blankett enligt Bil. C till Med.-styr:s kungörelse den 29 maj 1937 ang. veterinärintyg för köttexport.

Veterinärstyrelsen 1965. 2 000 ex. Br. Carlsson Varberg 651875

SWEDEN

Form. D.

Veterinärintyg för köttexport.
KINGDOM OF SWEDEN
 The Royal Veterinary Board of Sweden.



Official Meat-inspection certificate for pork
 and porkproducts.

(For Shipment to United States of articles of a kind prepared customarily to be eaten without cooking, which contain muscle tissue of pork).

Place (avsändningsort) Sweden
 Country Date (datum och år) 19

I hereby certify that the article or articles herein described are of a kind prepared customarily to be eaten without cooking, and contain muscle tissue of pork which, when fresh or freshly cured in salt, were subjected to a temperature not higher than 5°F. for not less than 20 days, or otherwise treated as specified by the Chief of the Bureau of Animal Industry, and that said articles contain no muscle tissue of pork which has not been treated as herein specified.

Undertecknad intygar härmed att nedan angivna köttvaror beretts på sådant sätt att de kunna förtäras utan föregående kokning, att de innehålla kött (muskelvävnad) av svin, som i färskt eller lätt saltat skick förvarats under minst 20 dygn vid temperatur av högst 5°F. (-15°C.) eller behandlats på annat sätt i enlighet med av Bureau of Animal Industry givna föreskrifter samt att köttvarorna icke innehålla kött (muskulatur) av svin, som icke behandlats i enlighet med här angivna bestämmelser.

Kind of product.
 (Varuslag)

Number of pieces or
 packages.
 (Antal kolly)

Weight.
 (Vikt)

Identification marks on meats and packages
 (Å kött eller emballage anbragta veterinära kontrollmärken)

Consignor
 (Avsändare)

Adress

Consignee
 (Mottagare)

Destination
 (Adressort)

Shipping marks
 (Avsändarens befraktningsmärken)



(Signature)

Veterinary inspector authorized by the Royal Veterinary Board of Sweden
 Av Veterinärstyrelsen förordnad besiktningsveterinär.



N.

REPUBLICA ORIENTAL DEL URUGUAY
MINISTERIO DE GANADERIA Y AGRICULTURA
DIRECCION DE GANADERIA

Sección: INDUSTRIA ANIMAL

Certificado Oficial de Inspección de Carnes

MINISTRY OF LIVE STOCK & AGRICULTURE
BUREAU OF ANIMAL INDUSTRY

Official Meat — Inspection Certificate

Montevideo,

N.º

Certifico que la carne y demás productos alimenticios de origen animal que se indican a continuación, provienen de vacunos, ovinos, porcinos o cabríos que recibieron inspección veterinaria ante-mortem y post-mortem al ser sacrificados, y que dicha carne y demás productos alimenticios de origen animal, son sanos, salubres y en toda forma aptos para alimentación humana, no habiendo sido tratados ni conteniendo preservativo alguno, materias colorantes u otras sustancias o permitidas por las disposiciones del Departamento de Agricultura de

que rigen la inspección de carnes, así como que dichas carnes y demás productos de origen animal han sido elaboradas en este País en condiciones sanitarias.

I hereby certify that the meat and food products herein described were derived from cattle, sheep, swine, or goats which received ante-mortem and post-mortem veterinary inspection at the time of slaughter, and that such meat and meat food products are sound healthful wholesome, and otherwise fit for human food and have not been treated with, and do not contain any preservative, coloring matter or other substance not permitted by the regulations of the Department of Agriculture governing, meat inspection and that said meat and meat food products have been handled only in a sanitary manner in this country.

CLASE DE PRODUCTO KIND OF PRODUCTS	N.º DE PIEZAS Number of Pieces	P E S O WEIGHT
.....
.....
.....
.....
.....
.....
.....
.....
.....
.....

Observaciones:

Remarks:

Sello de identificación de las carnes y piezas:
Identification marks on meat and packages:

Remitente
Consignor

Dirección
Address

Consignatario
Consignee

Destino
Destination

Marca de Embarque
Shipping marks

Vapor
Steamer

Firma:
Signature:

.....
Firma del agente o empleado del cargador
Signature of the agent or employee of the Shipper

Título Oficial:
Official Title:

YUGOSLAVIA



FEDERATIVNA NARODNA REPUBLIKA JUGOSLAVIJA

Savezna uprava za poslove veterinarstva

Obrazac A

UVERENJE O PREGLEDU MESA

Mesto Datum

Narodna Republika

Ovim potvrđujem da meso i proizvodi od mesa ovde opisani potiču od goveda, ovaca, svinja ili koza nad kojima su vršeni veterinarski pregledi pre, za vreme i posle klanja, i da su to meso i proizvodi od mesa dobri, zdravi, valjani i u drugom pogledu pogodni za ljudsku ishranu, da nisu obrađeni i da ne sadrže bilo kakvo sredstvo za konzerviranje, materiju za bojenje ili drugu supstancu, koja nije odobrena propisima Ministarstva poljoprivrede SAD o regulisanju pregleda mesa, čijim primerkom raspo-
lažem, kao i da se navedenim mesom i prehranbenim proizvodima od mesa rukovalo u ovoj zemlji samo na higijenski način.

Vrsta proizvoda	Broj komada ili paketa	Težina
.....
.....
.....
.....

Oznake za raspoznavanje na mesu i paketima

Pošiljalac

Adresa

Primalac

Mesto opredelenja

Oznaka pošiljke (otpreme)

(Potpis)

(Mesto pečata)

Veterinarski inspektor

YUGOSLAVIA



FEDERATIVNA NARODNA REPUBLIKA JUGOSLAVIJA

Savezna uprava za poslove veterinarstva

Obrazac B

UVERENJE O PREGLEDU MESA

(za svinjsko meso i proizvode od svinjskog mesa)

Mesto

Datum

Narodna Republika

Ovim potvrđujem da proizvod ili proizvodi ovde opisani pripadaju vrsti koja se obično jede bez kuvanja, i sadrže svinjsko mišićno tkivo koje je kao sveže ili sveže usoljeno meso bilo izloženo temperaturi koja nije viša od 5° F u roku od najmanje 20 dana, ili je drugačije tretirano kao što je odredio direktor Odeljenja za pregled mesa Ministarstva poljoprivrede SAD, i da pomenuti proizvodi ne sadrže mišićno tkivo svinja s kojim nije postupljeno kao što je ovde označeno.

Vrsta proizvoda	Broj komada ili paketa	Težina
.....
.....
.....
.....

Oznake za raspoznavanje na mesu i paketima

Pošiljalac

Adresa

Mesto opredelenja

Oznake pošiljke (otpreme)

(potpis)



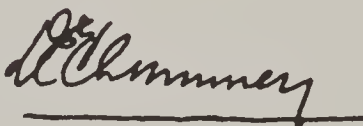


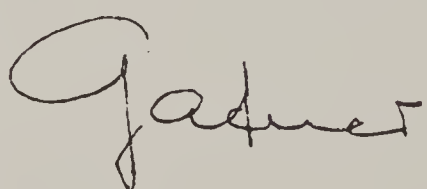

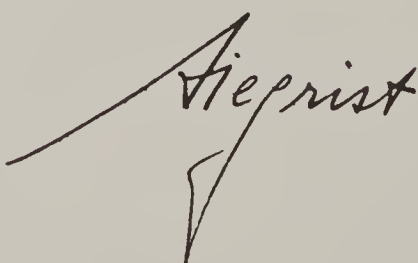
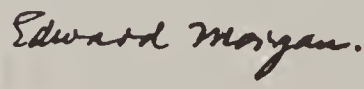
(Mesto pečata)

Veterinarski inspektor.

327.39 Certificates in the English language and exact form prescribed by Section 327.6(a) of the Meat Inspection Regulations are acceptable to cover the importation of meat and meat food products from the countries listed hereafter when signed by authorized officials of the countries whose names and signatures have been approved and published:

Luxemburg - Switzerland - Venezuela

The names and facsimile signatures of such foreign officials follow:

Country and name	Signature
<i>Luxemburg</i>	
Edouard Loutsch.....	
Marcel Theisen.....	
Emile Schummer.....	
<i>Switzerland</i>	
Dr. Andreas Nabholz --	
Dr. Riet Koenz - - - -	
Dr. Peter Gafner - - - -	
H. Ries - - - -	
Siegrist - - - -	
<i>Venezuela</i>	
Edward Morgan.....	

PART 328 - DEFINITIONS AND STANDARDS OF IDENTITY

328.1 The following quoted memorandum clearly indicates the position of the Food and Drug Administration in regard to oleomargarine factories operating under our inspection.

"The Meat Inspection Program maintains inspection under the Meat Inspection Act in establishments manufacturing oleomargarine using animal fats in whole or in part as an ingredient of oleomargarine if interstate movement is contemplated. This inspection deals with sanitation of the factory and wholesomeness of all raw materials and accuracy of labeling. The Meat Inspection Program inspector exercises supervision over the processing, during the time that the factory is operating, on animal fats and at other times so far as general sanitary conditions go. During periods when vegetable oleomargarine only is being produced there is no processing inspection in the factory by the Meat Inspection Program.

"If the oleomargarine plant while operating exclusively on vegetable product becomes a nuisance and likely to contaminate the meat packing establishment, the Meat Inspection Program takes such action as will bring about correction of the unsatisfactory condition.

"It is unnecessary for Food and Drug to make inspection of oleomargarine factories during periods of time while Meat Inspection Program inspectors are in the plant even though both vegetable and animal oleomargarine are being produced at the same time. Inspection should be made by Food and Drug if there are extended periods of time during which the plant is operating only on vegetable oil and Meat Inspection Program inspectors are not continuously present.

"During your routine coverage of oleomargarine factories, contact the supervisor of Meat Inspection Program in each factory operating under Meat Inspection Program inspection. A mutually agreeable plan should be developed with him which will insure adequate coverage of sanitation of oleomargarine operations of the factory by Meat Inspection Program or Food and Drug Administration or both, with the former supervising the preparation of oleomargarine containing animal fat and the latter being responsible for oleomargarine composed exclusively of vegetable fats or oils."

PART 329 - INSPECTION AND HANDLING OF HORSE MEAT
AND PRODUCTS THEREOF

329.1 The reference to equine meat used in the Horse Meat Act has been interpreted to apply to horses and is not extended to mules, burros, and the like.

329.2 Although it is clear that horse meat may not be prepared or handled in any establishments in which cattle, sheep, swine, or goats are slaughtered or product thereof is prepared or handled, establishments operating under our horse meat inspection are permitted to receive into such establishments federally inspected meat or meat byproducts derived from cattle, sheep, swine, or goats for the purpose of using such product with horse meat or horse meat product in the preparation of pet food. However, products derived from cattle, sheep, swine, and goats if not used in the preparation of pet food, may not be distributed from the horse meat establishment except in the original closed packages in which they were received. This prohibits the shipment from a horse meat establishment of unpackaged carcasses, quarters, and wholesale cuts derived from cattle, sheep, swine, and goats.

329.3 It has been found very convenient to have an elevated walkway around the horse pens so that animals can readily be observed from a dorsal aspect which easily brings into focus two parts of the horse often affected, namely, polls and withers.

329.4 Sections 309.6 and 309.9 of the Regulations pertain to any and all animals showing symptoms of, or affected with, anthrax, rabies, tetanus, parturient paresis, and railroad sickness.

329.5 It is important to report the identity of animals found on ante-mortem or post-mortem examination to be affected with contagious and communicable diseases by rapid means of communication if the circumstances warrant or on the usual Form ANH-2-11C.

329.6 Horse livers condemned on post-mortem inspection need not be reported.

329.7 Carcasses of horses that have been subjected to hyperimmunizing procedures against such human pathogenic microorganisms as meningococci and streptococci should not be passed for human consumption since these organisms may still be present and viable in the body for varying periods after the final injection of the cultures. Moreover, horses so treated should not be slaughtered for animal food because of the danger of contaminating humans who handle the carcasses or parts of the animals.

329.8 Horses used for the production of gas gangrene, tetanus, or diphtheria antitoxins, although not subject to inoculation with living pathogenic bacteria, are nevertheless considered unsuitable for slaughter for human food. The toxins injected into these animals are very powerful and noxious.

329.9 Various methods are employed to kill horses. Some methods result in the contamination of the head and adjacent cervical tissues. A careful inspection should be made of these parts and any contaminated portions must be disposed of according to the findings.

329.10 It is necessary to remove sufficient dorsal bones of the head (frontal, nasal) to expose for inspection the nasal septum and turbinate bones with the adjacent mucous membrane.

329.11 Deposits of melanin are often found in the axillary and medial scapular regions of white or light gray horses. Therefore, these areas in white or light gray horses must be exposed as part of the routine post-mortem inspection. When examinations disclose melanin in these parts, the inspection should extend to the ribs and costal muscles. This does not imply that other horses are not similarly affected because such lesions have been found in dark colored horses.

329.12 A careful examination must be made of the atlantal and supraspinous bursa and surrounding structures in all horse carcasses since these areas are common seats of infections.

329.13 The regular 2½-inch rubber brand may be used to apply the inspection legend and establishment number on the outer cloth covering of horse meat or horse meat product. However, this does not relieve the requirements that such covering plainly and conspicuously bears the inscription "Horse Meat" or "Horse Meat Product," whichever is applicable. The words "Horse Meat" or "Horse Meat Product" should be placed in close proximity to the imprint of the 2½-inch rubber brand wherever it appears on the covering.

329.14 A reading of the Federal Horse Meat Act indicates that it was the intention that horse meat or horse meat product be plainly and conspicuously labeled, marked, branded, or tagged "Horse Meat" or "Horse Meat Product," as the case may be, if interstate movement is involved. This means that all horse meat or horse meat product leaving an official establishment must be so identified. Likely, the intent of the law and regulations is being properly carried out at your Circuit, but we feel that emphasizing its importance is in order. Even though horse meat in chunks or larger pieces or horse meat product is packed in properly marked barrels or other large shipping containers, such horse meat or horse meat product should bear the markings as required by the Act and Regulations, applied either by the official brand or other approved means. An exception may be made on inspected and passed horse meat which moves from one official establishment to another under seal.

329.15 A study of various methods used and investigation with a number of different formulas of green ink gave information which should be helpful in obtaining permanent legible marks of inspection on horse meat. The area where the brand is to be applied must be free of surface water. This may be accomplished by using a scraping device attached to the handle of the brand or allowing the carcass to hang for a short time before branding.

Experience with hot ink brands did not indicate that this type of brand produced a more acceptable mark on the carcasses than cold ink brands. However, on boneless horse meat, such as horse tenderloins, the hot ink brand produced a more acceptable mark. The formula for the green ink that gave the most satisfactory results follows:

	<u>Percent</u>
FD&C Green No. 3 (fast green FCF) -	3½
Dextrose (corn sugar) -----	3
Water -----	16
Edible shellac -----	2
95 percent ethyl alcohol -----	75

329.16 In addition to the green domestic meat label for horse meat or horse meat food products, the words "Horse Meat" or "Horse Meat Product," as the case may be, should be stenciled in letters at least one inch in height on the barrels or other large shipping containers. Such markings on burlap, paper, or other similar barrel covers are not sufficient.

329.17 Facsimiles of approved foreign horse meat inspection certificates follow.

CANADA

ORIGINAL to be attached to Export Entry Form B.13 and accompany the shipment to the port of export from Canada where the agent of the transportation company shall hand same to the proper official of the Customs at the port of exit from Canada.

Form PHA 26
8717-1CX-10-48

DOMINION OF CANADA

N^o 2669 H.M.

DEPARTMENT OF AGRICULTURE



HEALTH OF ANIMALS DIVISION

MEAT AND CANNED FOODS

HORSE MEAT

Place..... Date.....

This is to certify that the meat or meat food products herein described were derived from animals which received ante-mortem and post-mortem veterinary inspection at the time of slaughter, and that said meat and meat food products are sound, healthful, wholesome and otherwise fit for human food, and have not been treated with and do not contain any preservative, colouring matter, or other substance not permitted by the Meat and Canned Foods Act and Regulations, and have been handled only in a sanitary manner in this Country.

HORSE MEAT	Number of Pieces or Packages	WEIGHT

Identification marks on meats and packages

Consignor..... Address.....

Consignee..... Destination.....

Shipping marks.....

(Name of Vessel or Car No. and Initials)

Inspector under Meat and Canned Foods Act.

FORMA HUM 19-A

MEXICO
(Horse Meat)



Certificado No. _____

REPUBLICA MEXICANA
SECRETARIA DE AGRICULTURA Y GANADERIA
DIRECCION GENERAL DE GANADERIA

EXPORTACION A: _____

CERTIFICADO
DE INSPECCION DE CARNE DE CABALLO

(Lugar)_____
(Fecha)

Por el presente se certifica que la Carne de Caballo y los Productos de Carne de Caballo que aquí se detallan, proceden de Caballos que fueron sometidos a Inspección Sanitaria Veterinaria Federal, antes, durante y después de ser sacrificados en los términos de la Ley del 31 de diciembre de 1949, y que dicha Carne de Caballo y Productos alimenticios de Carne de Caballo se encuentran en perfectas condiciones sanitarias, siendo por tanto adecuados para la alimentación humana y que no contienen ni han sido tratados con ningún preservativo, materia colorante u otras sustancias prohibidas por la Ley antes citada y que tal Carne de Caballo y Productos alimenticios de Carne de Caballo, han sido manejados en forma completamente higiénica.

MARCAS DE IDENTIFICACION EN LA CARNE DE CABALLO

Nombre del Establecimiento T.I.F. Productor:

Vía:

Número de Registro:

Destino:

Remitente:

Consignatario:

Procedencia:

Marcas de Embarque:

Detalle del Cargamento:

(Firma del Funcionario Federal autorizado)_____
(Sello de la Direc. Genl. de Ganaderia)

329.18

A. The import mark of inspection on horse meat and horse meat products should be applied with green ink by means of a hexagonal import brand when applied directly to the horse meat or horse meat product.

B. When applied to the container, the regular 2½-inch import brand should be used with the words "Horse Meat" in letters not less than one-half inch in height appearing adjacent to the brand. The markings on containers may be applied by means of regular marking ink.

1. In addition to the designation on the container, the larger pieces of boneless horse meat must be conspicuously branded "Horse Meat" with green ink. At least one such brand will be required for each 10 pounds of meat. Thus, in a container of 100 pounds net weight, a minimum of 10 brands is to be evident when the meat is defrosted for import inspection.

2. Labeling information on containers of horse meat must be printed. Paper labels attached to cartons are not satisfactory.

3. The applicant for import inspection must show on the Form MI-410, Import Meat and Meat Products Report, the name and address of the ultimate consignee of the shipment. The importer or his agent is, therefore, required to declare the final destination of the horse meat in Section C, Item 8, of the form. The recording of a broker, intermediate agent, or warehouse as the consignee is not satisfactory.

Inspection of horse meat offered for importation will not be undertaken until conditions 2 and 3 of paragraph B of this section are met. Horse meat will be refused entry if condition 1 of paragraph B of this section is not fulfilled.

PART 340 - THE IDENTIFICATION, FOOD INSPECTION, AND CERTIFICATION SERVICES

340.1 The Identification Service provides for maintaining the identity of U. S. Inspected and Passed product (including imported product) as such when it is divided into smaller units at a location other than an official establishment under the supervision of an inspector of this Program. It can be used to apply the marks of inspection to parts removed from a federally inspected carcass, such as beef tenderloins; to parts of a pork loin, a full beef loin, or short loin when divided into two or three parts, etc. It can also be used for the identification of boneless meat, steaks, chops, roasts, and similar size meat cuts taken from fresh carcasses or parts thereof that are identifiable as being federally inspected and passed and so marked and are sound, wholesome, and fit for human food. Sufficient supervision is necessary to carry over to the end product its identification as being U. S. Inspected and Passed and so marked and properly labeled. Also, adequate attention will be paid to the sanitation, equipment, personnel, etc., in the area used for preparing such cuts.

The mark of inspection is to be applied to the meat or to the container by means of special MI brands furnished by the Washington office, and in no case to be applied by any other means. The identification brand should bear the Circuit location. Boxes, packages, etc., will be marked with a 2½-inch brand featuring the establishment number assigned to that particular location. The latter brands are constructed so that the numbers are interchangeable.

The Identification Service may now be used to supervise the preparation of meat for stewing (approximately 1-inch cubes, providing grinding of meat is not involved) and to identify consumer-size packages.

Labeling material for meat or meat food products packaged in consumer-size packages will bear the marks of Federal meat inspection as illustrated in Section 317.2(b) of the Meat Inspection Regulations. An establishment number in the 3000 series will be assigned. The finished label must be approved by the Labels, Standards and Packaging Branch. All labeling material bearing the marks of inspection under the Identification Service must be delivered to the inspector upon being received from the printer. The labeling material will be inventoried and kept under Department lock or seal at the establishment and will be used only under the supervision of an inspector.

Beef carcasses retained because of *Cysticercus bovis* infestation and hog carcasses frozen for certified pork may be held in freezers at other than federally inspected establishments under the Identification Service. This permission is granted when the Officer in Charge, after examining the facilities, is satisfied the retained carcasses can be satisfactorily controlled.

Identification Service may be used to extend services to public warehouses desiring to act as certified storage depots for federally inspected boneless meats. The Identification Service cannot be used for supervising any processing or meat chopping operations. These activities would need to be done in an establishment operating under Federal meat inspection.

The system of control defined for handling of meat in approved warehouses is based on the understanding that the units will remain intact. If cartons from a lot are opened for examination, it must be done under Identification Service in order for the product to maintain its identity as a sealed lot.

Please notify the Processed Meat Inspection Division when establishments have not used their grant of Identification Service for a period of more than one year.

Under such circumstances, the Identification Service will be canceled unless the establishment shows a need for its retention.

340.2 The Certification Service is provided so that we can respond to a request for specific certification for export product which is in addition to the certification contained in our regular export certificate. Examples of the types of certification statements that are to be done under the Service are the additional certification required on Form MI-410-11 for lard exported to Germany and which limits the time of production of the lard and other restrictions and statements concerning the origin of animals so that the meat can be certified as being derived from areas free of Vesicular Exanthema. To make these certification statements which are beyond our normal meat inspection responsibilities requires additional time for which we must be reimbursed -- including all time required to obtain the factual information on which to base certain kinds of certificates, and maintain the identity of the product, as well as the time required to make out the certificate. All subsequent varying statements and certifications must be specifically authorized by the Processed Meat Inspection Division, although the original application will suffice. Any requests with which you are unfamiliar should first be cleared.

340.3 The Food Inspection Service provides for the supervision of the preparation of certain food items containing meat, meat byproducts or meat food products as ingredients, but which are not subject to the Meat Inspection Act. The application for this Service should be accompanied by a brief description of the food article proposed to be prepared under this Service. A complete description of the method of preparation together with the formula of preparation and a percentage list of the ingredients used must be included. It would also be expedient to include a sketch of the label proposed to be used with the food article.

A facility review will be made by the Officer in Charge when instructed to do so after the application has been forwarded to the Processed Meat Inspection Division. Blueprints of the facility will not be required since the operation of the Food Inspection Service will, in most cases, be on an intermittent basis. In making the review, the Officer in Charge will apply the same facility requirements as would be accepted for a similar establishment operating under Federal meat inspection or the Identification Service.

Labeling material for food articles prepared under this Service will bear the marks of Federal meat inspection as illustrated in Section 317.2(b) of the Meat Inspection Regulations. An establishment number in the three thousand series will be assigned upon approval of the application. The finished label must be approved by the Labels, Standards and Packaging Branch. All labeling material bearing the marks of inspection must be delivered to the inspector upon being received from the printer. The labeling material will be

inventoried and kept under Department lock or seal at the establishment and will be used only under supervision of the inspector.

The same basic sanitary requirements will apply as are deemed necessary in establishments operating under Federal meat inspection. Equipment for handling the product must meet the same standards of construction. Employees' conduct, practices and product handling techniques will meet our usual standards of sanitation.

Only U. S. Inspected and Passed meat, meat byproducts and meat food products will be used as ingredients of the food article. At the time these products are offered as ingredients they must be sound, wholesome and otherwise acceptable. Other ingredients used in the manufacture of the food article must also meet the same standard for wholesomeness necessary for the manufacture of meat food products in federally inspected establishments. When laboratory sampling of ingredients is necessary, the inspector should request the laboratory to indicate time to be charged on the form as is done for specification examination work. This laboratory time is reimbursable and will be shown on Form C&MS 488. Inspection will be continuous when the inspected food article is being prepared, packaged and labeled. Regular export stamps and certificates may be issued at the applicant's request.

340.4 Application for Identification Service, Certification Service, Food Inspection Service and Specification Examination Service should be made on Form MI-416-6. The application for Identification Service should be accompanied by comments from the Officer in Charge describing the operation involved and the acceptability of the facilities.

340.5 Charges should be made as outlined in C&MS Instruction 425-1 at established billing rates contained in the Federal Register.

Local transportation costs should not be charged in furnishing the service. However, should it be necessary to travel outside the confines of what is normally considered the Circuit, time spent going to and from the point of inspection as well as any per diem, mileage, or other reimbursable expenses should be charged against the one receiving the service.

Each time a plant receives inspection service, the meat inspector shall complete an original and two copies of MI-411, as follows:

- A. Fill in date inspection occurred.
- B. Identify:
 - 1. Circuit, by code and name,
 - 2. Establishment where inspection occurred, by number.
- C. Record service performed, as follows:
 - 1. For Identification Service, record number of pounds of fresh meat inspected.

2. For Food Inspection Service, record the name and number of pounds of each article inspected.

3. For approved warehouse examination or other identification service, identify under "Remarks."

D. Show total number of hours worked for all services performed under Section 'C above. Include travel time and time required for the preparation of this and other necessary reports.

E. Obtain the signature of the appropriate plant representative.

The meat inspector shall distribute MI-411 as follows:

A. Original to Program Records Unit
C&MS Meat Inspection Administrative Staff
211 Stockyards Station
4101 South Halsted Street
Chicago, Illinois 60609

B. Duplicate to Officer in Charge, Meat Inspection Circuit.

C. Triplicate should remain in the book. Completed books should be retained by the meat inspector for 30 days and then destroyed.

The Meat Inspection Program is authorized to certify inedible material for export on a reimbursable basis for the Animal Health Division. In order to do this, two forms C&MS 488 must be completed. The first form is used to bill the company for the Animal Health Division. The second form is used to bill the Animal Health Division for the work performed by the Meat Inspection Program.

PART 380 - DESIGNATION OF METHODS

380.1 Conventional humane slaughter electric stunning devices produce animal anesthesia by passing an electric current through the brain of the animal. This is accomplished by placing two electrodes transparietally on the skull of the animal being stunned. Some official establishments have modified the conventional electrical stunning instruments by separating the two electrodes. Using this version, one electrode is placed on the animal's skull and the other on the body over the thoracic, abdominal or perineal region. With proper electrical dosage and uniform placement of the electrodes, desirable anesthesia can be produced. Excess dosage and in some animal species variable electrode placement will electrocute the animal with an immediate stoppage of heart and respiration. Carcasses from animals killed by the electrical charge should not be passed for food.

When electrical stunning instruments are used on livestock in official establishments, it is necessary to determine if anesthesia or death has been produced. Presence of pulse and respiration are basic in making this decision. If upon careful observation of the establishment's procedures, the veterinarian can determine that livestock are stunned properly before shackling and remain so through bleeding, the operations will be reported as in compliance with the Humane Slaughter Act.

If operations in the stunning area are not conducive to detecting the physiological signs of life, recovery tests should be made as follows. Immediately after stunning remove two or more unstuck animals from the conveyor or sticking platform. The stunned animals should not be dropped to the floor or otherwise roughly handled. Abuse of the stunned animal may in itself produce death. In the absence of any stimulation but while under constant inspection observation, the animal should be allowed to regain consciousness. Failure of any animal to recover would indicate that excessive electrical dosage or improperly placed electrodes had been used. When failure of the animal to recover is due to electrical charge or exposure time, the management should be instructed to adjust either or both factors immediately.

Experience has shown that independent and separate placement of electrodes in swine stunning operations should not be left to the operator. Providing death of the animal is not produced, the Division has no objection to placement of one electrode on the head of the animal just in front of the ears with the second electrode being placed over the thoracic region. To prevent misplacement of electrodes by operators in the absence of inspection personnel, the maximum distance between electrodes should be governed with a space limiting device. This may consist of a metal or plastic bar, rod or stout cord that will extend from the animal's head to a location over the thoracic region. Minimum distances between electrodes may be adjusted within the total length of the limiting device. In no instance, however, should it be possible to separate the electrodes for a distance greater than the total length of the limiting device. Continued failure to meet these requirements would be grounds for removal of an animal species from the humane slaughter identification listing. It is not necessary to use the fixed electrode positions while stunning sheep or calves.

Requirements of the Humane Slaughter Law dictate that animals stunned by electrical, chemical, mechanical, gunshot or other methods shall be unconscious before they are shackled, hoisted, thrown, cast or cut.

It has come to our attention some slaughterers are using stunning equipment which is ineffective in producing and maintaining animal unconsciousness throughout the slaughtering process. Under these conditions, carcasses prepared from such animals as a species are not eligible for humane slaughter identification. Veterinarians responsible for determining compliance should assure themselves through regular observations that designated stunning instruments are functioning properly, that they are being correctly applied, and that animals are being satisfactorily stunned. No animal species should be included in the monthly humane slaughter identification report when these requirements of the Humane Slaughter Law are not being regularly and conscientiously fulfilled.

It should be fully understood the existence of humane stunning instruments in any establishment does not automatically constitute humane slaughter for a given species.

PART 381 - IDENTIFICATION OF CARCASSES OF CERTAIN
HUMANELY SLAUGHTERED LIVESTOCK

381.1 The supervisory veterinary meat inspector located at the slaughtering establishment shall complete MI-403-4 in duplicate not later than the 4th day of each month indicating the method of slaughter the plant has used during the first four days and plans to use during the current month for each species expected to be slaughtered, and send both copies to the Officer in Charge of the appropriate Meat Inspection Circuit.

381.2 If the slaughtering establishment should, at any time during the month, either change the method of slaughter for any species, come into compliance for the first time, or discontinue the humane slaughter program during the month, the supervisory veterinary meat inspector shall complete an additional MI-403-4 in duplicate as soon as the program is modified, send the original directly to the Livestock Slaughter Inspection (LSI) Division, and send the copy to the appropriate Officer in Charge.

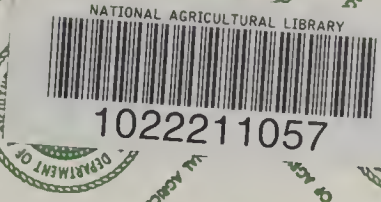
381.3 The Officer in Charge shall check each MI-403-4 for accuracy and completeness, resolve any questions with the supervisory veterinary meat inspector, and show that the report has been reviewed and concurred in by signing in the indicated space on MI-403-4. He shall ascertain that all reports for the Circuit have been received from all establishments that have slaughtered during the first four days of the month and complete MI-403-4 for any establishment that has not slaughtered during the first four days of the month, basing the report on slaughter methods used during the last previous operation. He shall send the originals to the appropriate District Director not later than the 10th day of the month, and retain one copy of each for the file.

381.4 Upon receipt of the copy of MI 403-4 showing that humane slaughter has been changed, the Officer in Charge shall review the MI-403-4 and resolve any questions with the supervisory veterinary meat inspector. He shall notify the LSI Division if any change should be made in the original of the MI-403-4. Whenever inspection is suspended or withdrawn from an official establishment, the Officer in Charge shall submit a MI-403-4 to the LSI Division with the notation of the date of suspension or withdrawal. No further report is necessary until the suspension is revoked.

381.5 The District Director shall check to make sure that a properly signed and completed form is received for each establishment in the District. As soon as all reports are received, he shall send them to the LSI Division for receipt not later than the 15th of the month.

D 3 2 8 6





NATIONAL AGRICULTURAL LIBRARY



1022211057